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1- scale print of MK II sten

1- scale print of MP-40

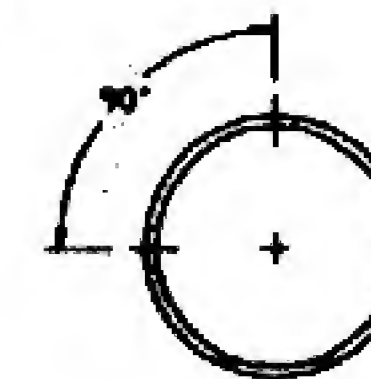
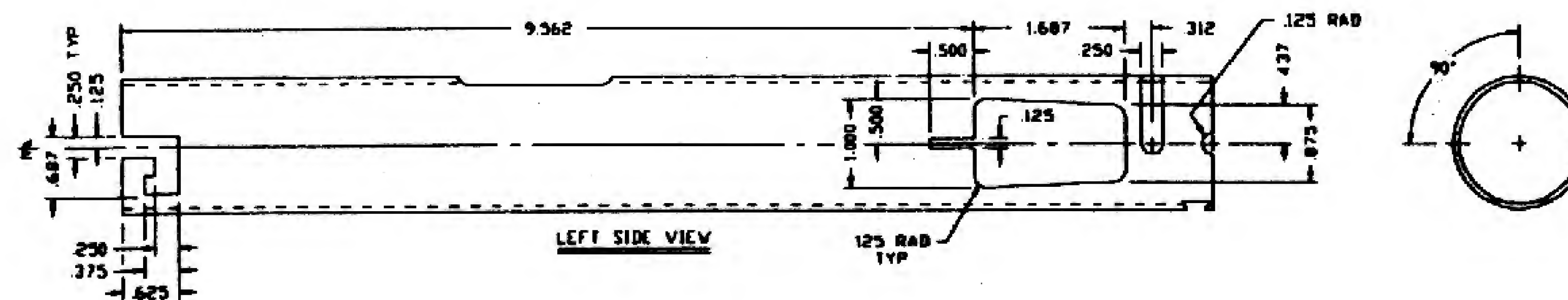
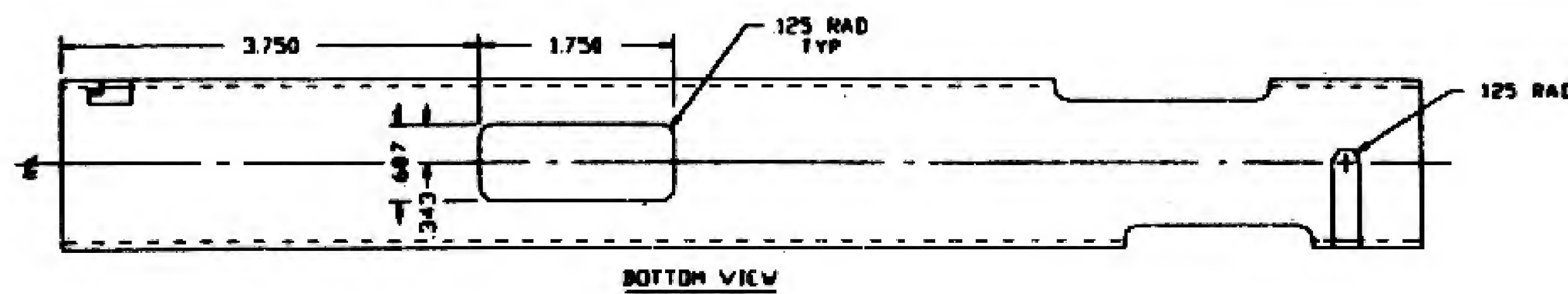
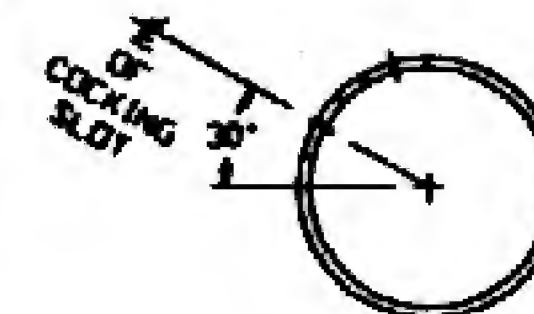
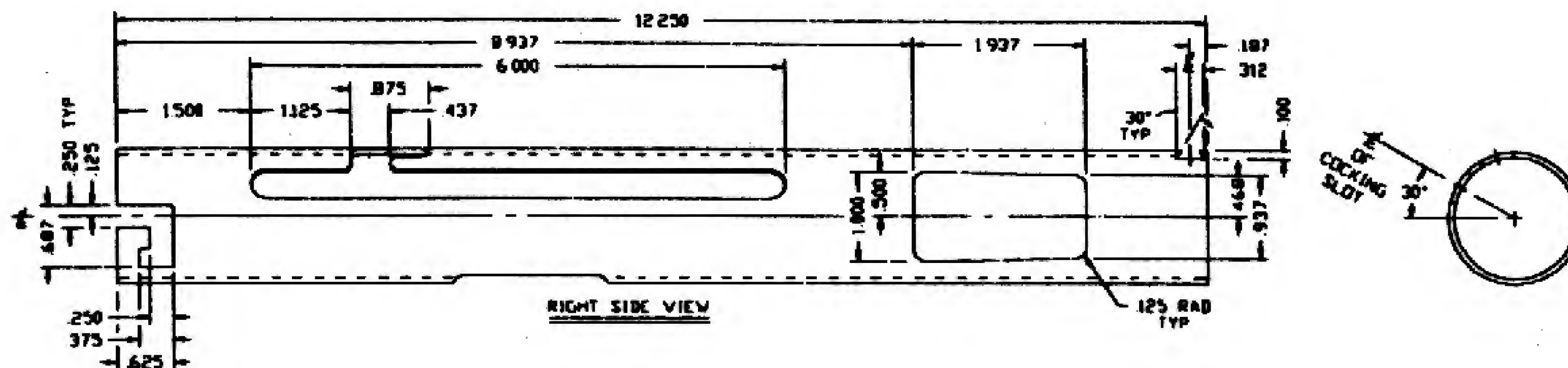
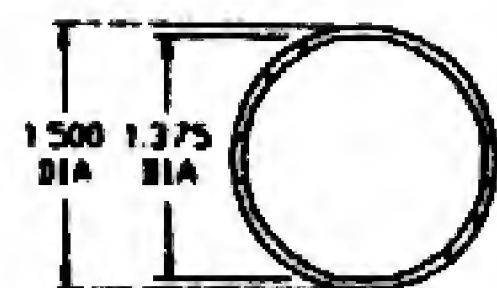
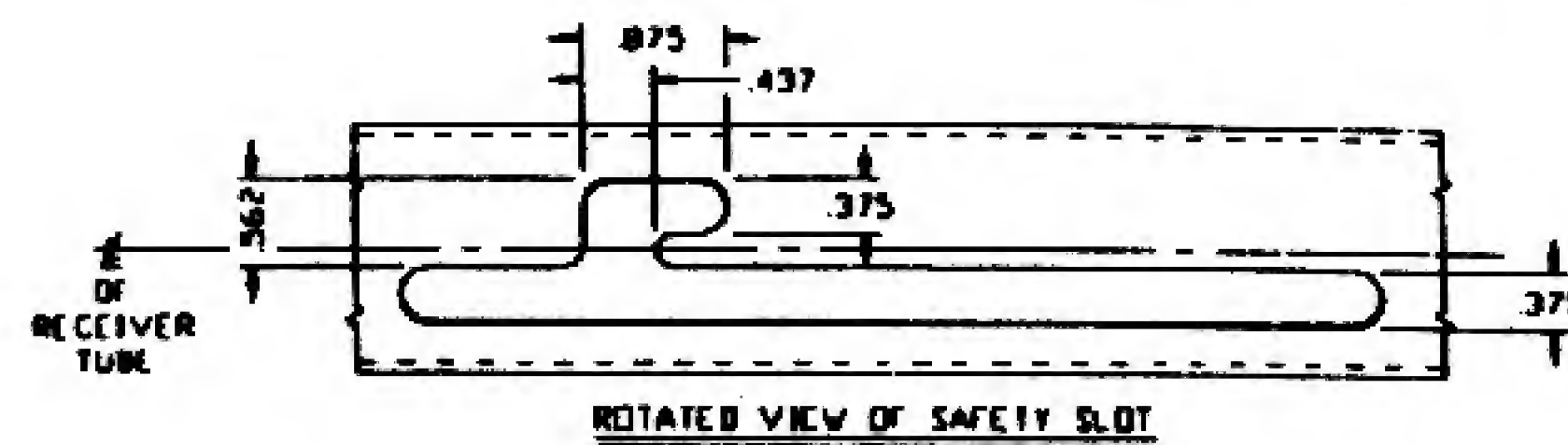
1- scale print of MK II sten compact

1- scale print of Yugoslav 56

1- scale print of BMG 50

right and left sides

PARTS SUPPLIERS ON LAST PAGE

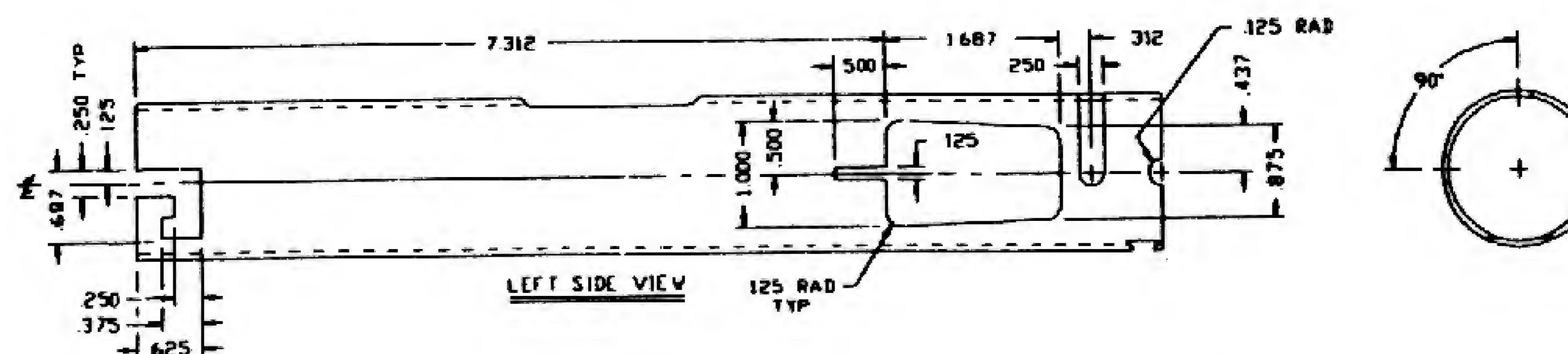
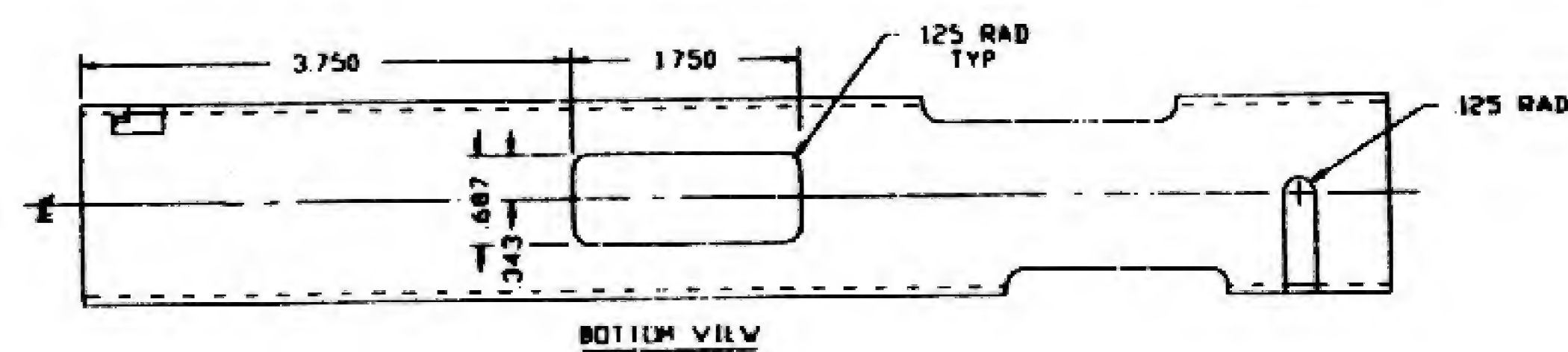
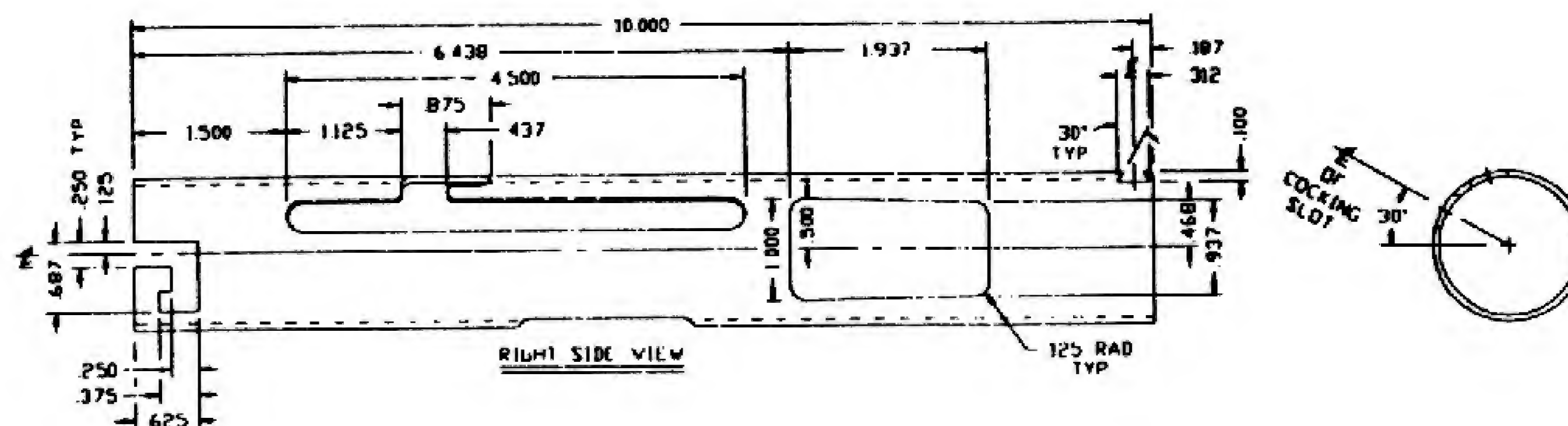
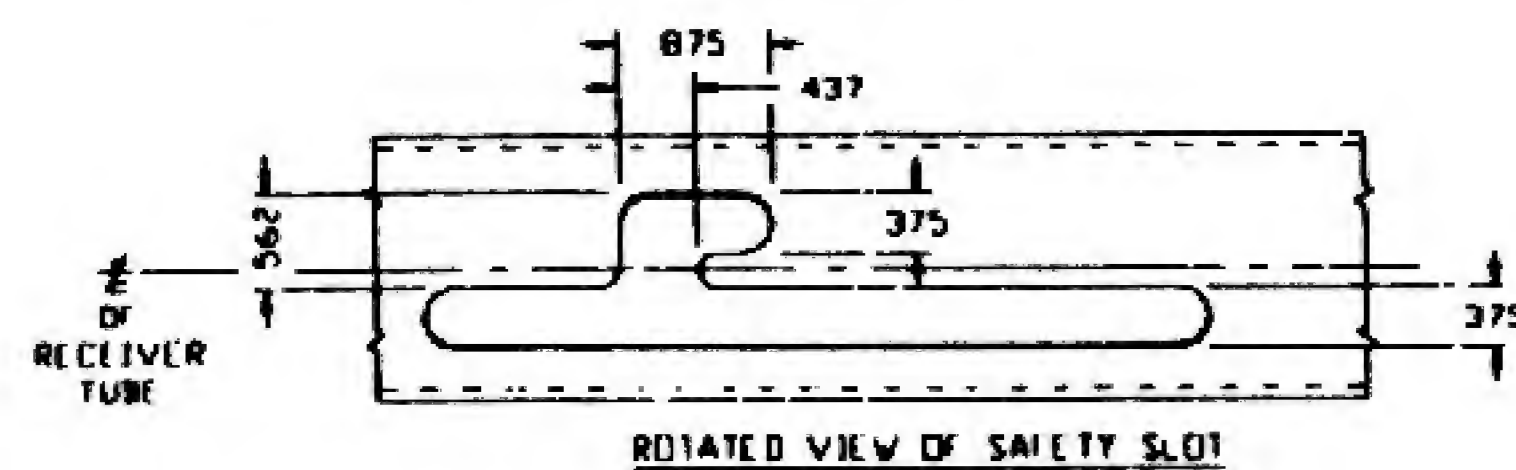
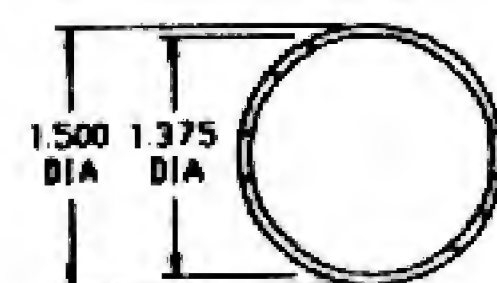


RESTRICTED
MATERIAL

CONFIDENTIAL

- NOTES:
1. MATERIAL - MILD STEEL SEAMLESS, DRAWN OVER MANDREL
1500 O.D. X 1375 I.D. (.050-.062 WALL)
 2. FINISH - PAINT BLACK

DESIGN	FULL	REVISION	SEE NOTE 1	DATE	NO. OF COPIES
DRAWN		FOR	SEE NOTE 2	DATE	NO. OF COPIES
TITLE	STEN MK-II RECEIVER (STANDARD MODEL)				NO. OF COPIES
					NO. OF COPIES



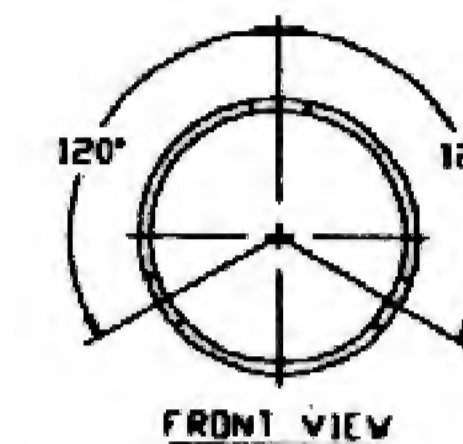
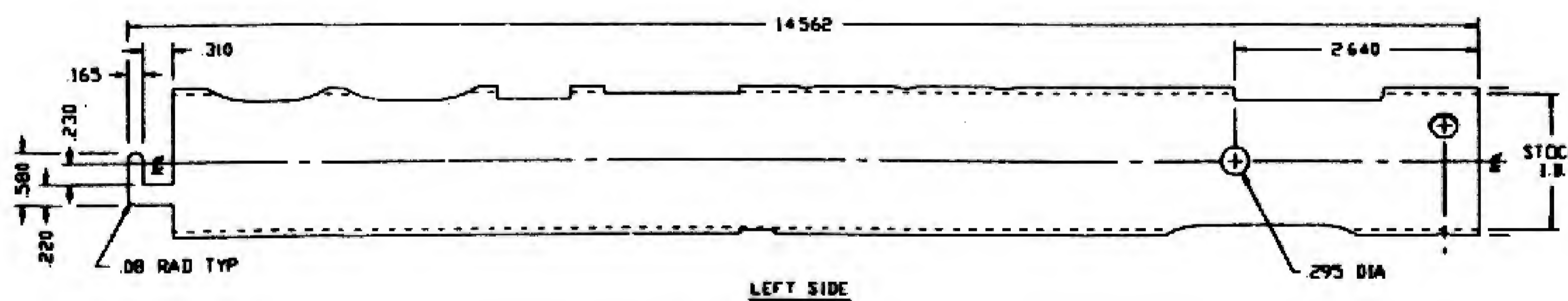
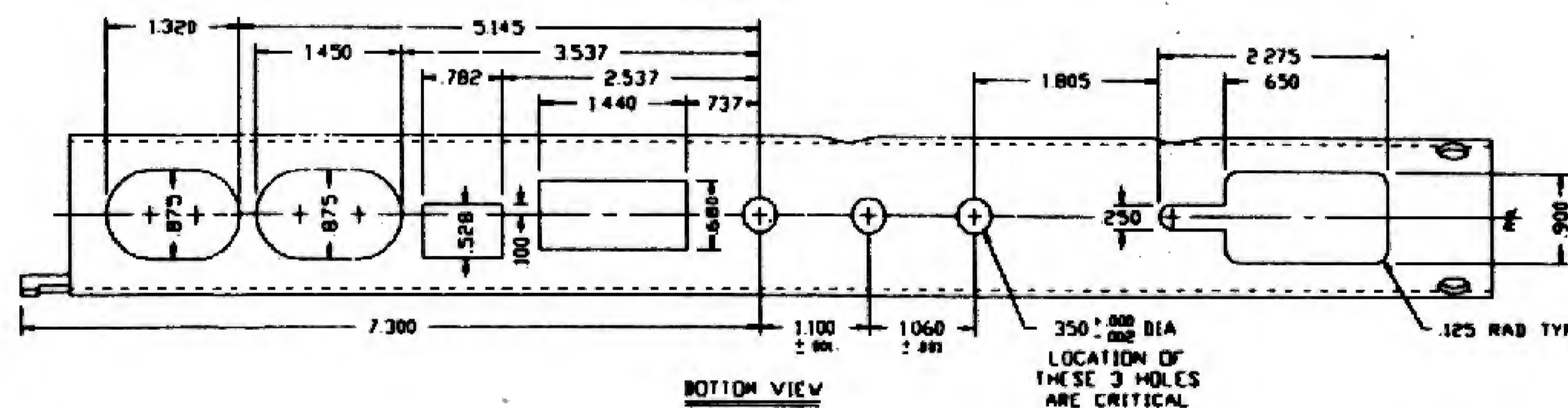
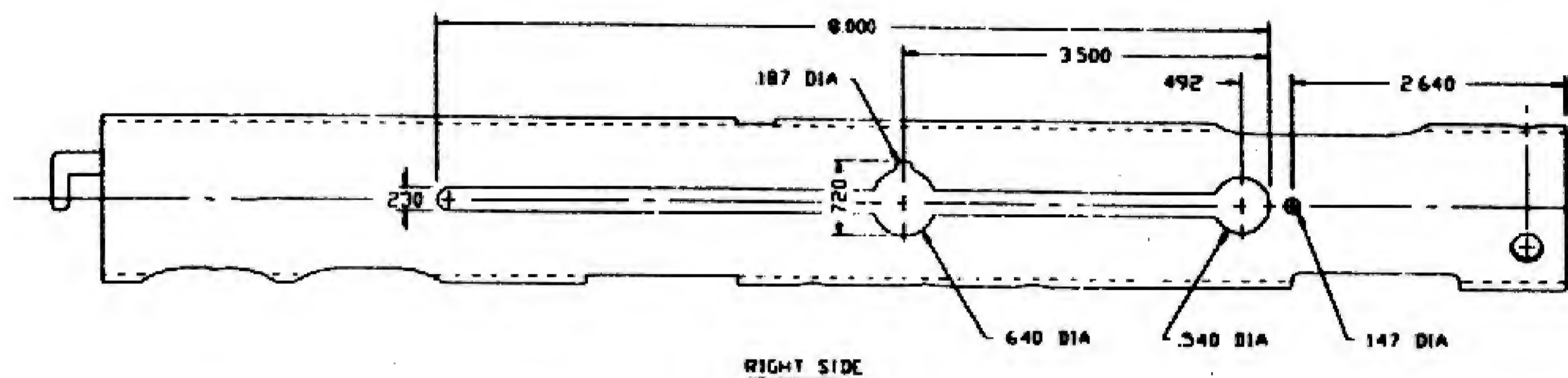
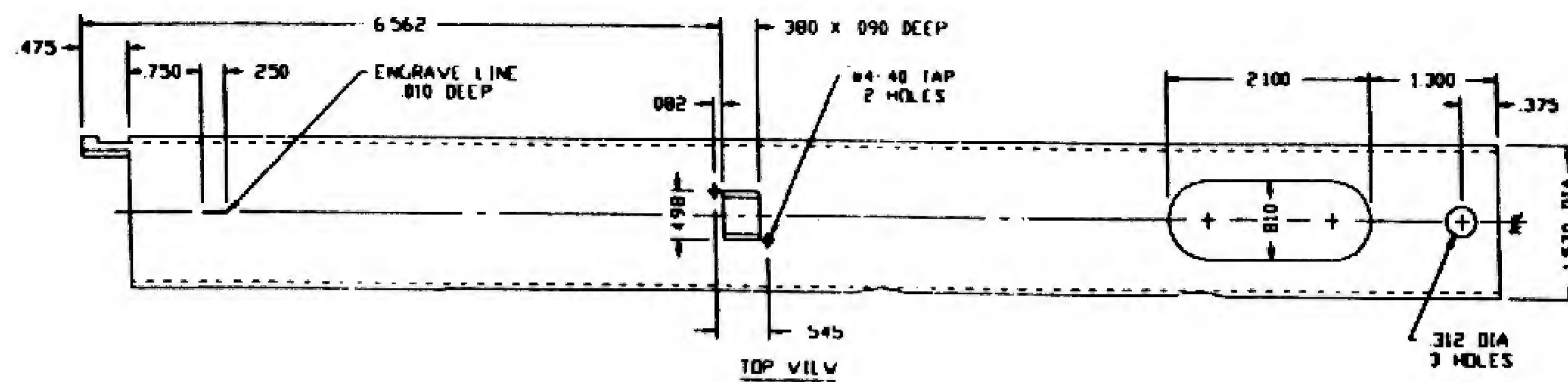
RESTRICTED
MATERIAL

CONFIDENTIAL

NOTES:

1. MATERIAL - MILD STEEL SEAMLESS, DRAWN OVER MANDREL
1.500 O.D. X 1.375 I.D. (.058-.062 WALL)
2. FINISH - PAINT BLACK

SCALE: FULL	MATERIAL: SEE NOTE 1	DATE	DESIGNED BY: [Signature]
DRAWN	FINISH: SEE NOTE 2	DATE	DESIGNED BY: [Signature]
TITLE: STEN MK-II RECEIVER (COMPACT MODEL)			REV. [Signature]
			NO.



METHOD OF ATTACHING
BARREL BUSHING
DRILL 312 DIA HOLES AT 120°
POSITIONED 375 FROM FRONT
AND ELECTRIC WELD
ALTERNATE FOR NON-GUN
COLD SOLDER OR SILVER SOLDER

NOTES
1 MATERIAL- 1.625 O.D. X .093 WALL D.D.M. STEEL TUBE
2 FINISH- BLUE
3 CALIBER- 7.62 TOKAREV OR 7.63 MAUSER

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MATERIAL

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SCALE	MATERIAL	DATE	REVISION
FULL	SEE NOTE 1		
	SEE NOTE 2		
TITLE	YUGOSLAV 56 RECEIVER		

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**

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1- scale print of OWEN MK II 1943

1- scale print of REISING

1- scale print of SPRINGFIELD M-60 lt. MG

PARTS SUPPLIERS ON LAST PAGE

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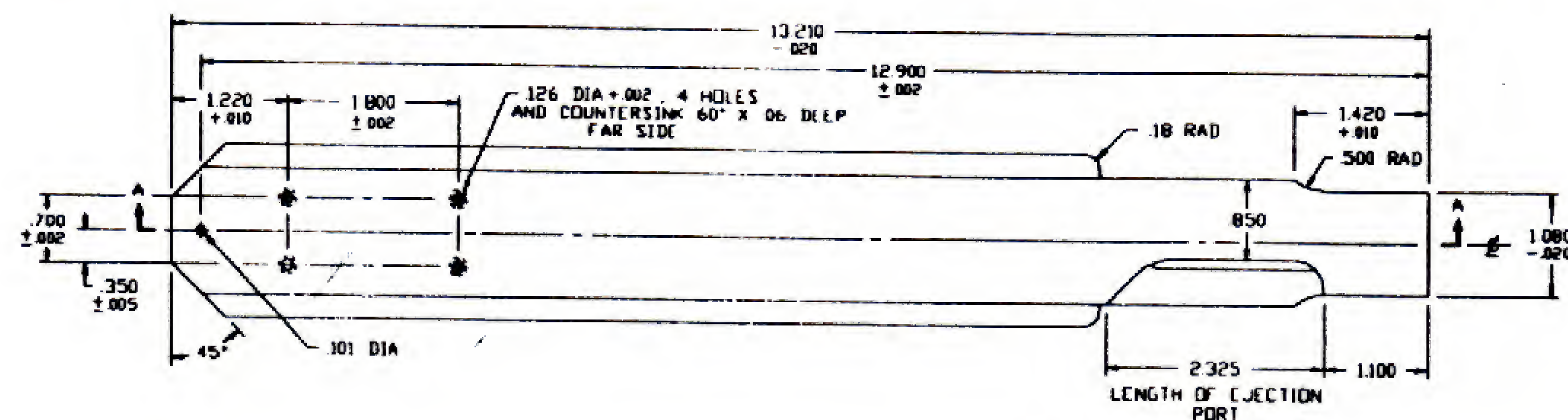
1- scale print of THOMPSON SUB MACHINE GUN M1A1

1- scale print of MK 1 and MK 1* LANCHESTER

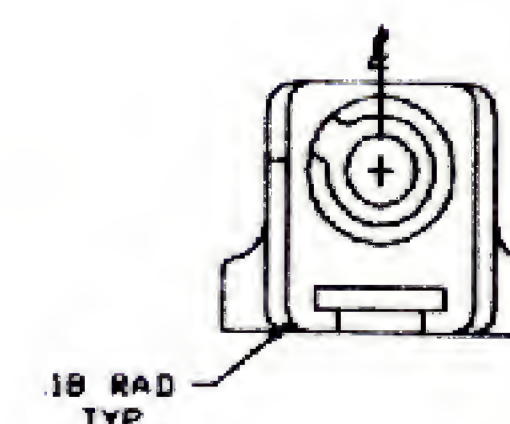
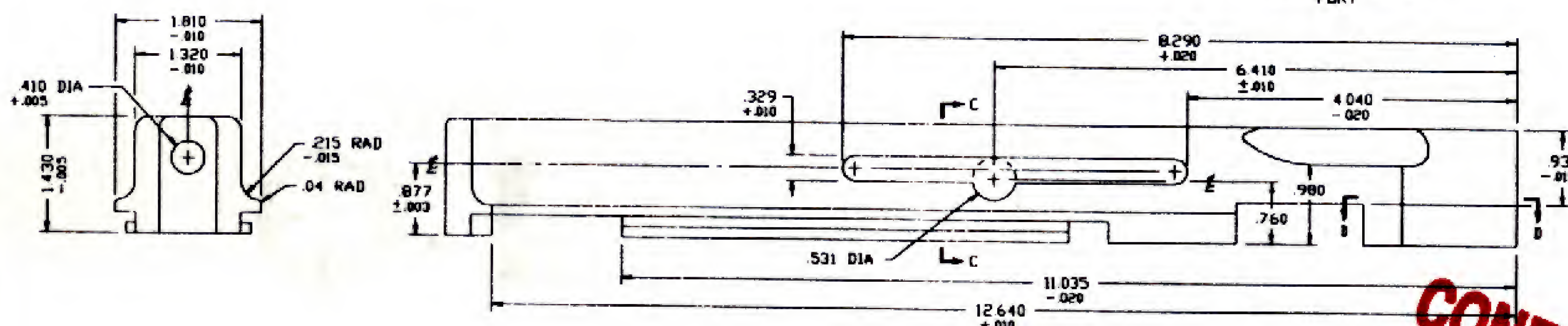
1- scale print of MODEL 37 right and left side plates

1- scale print of UD-M42

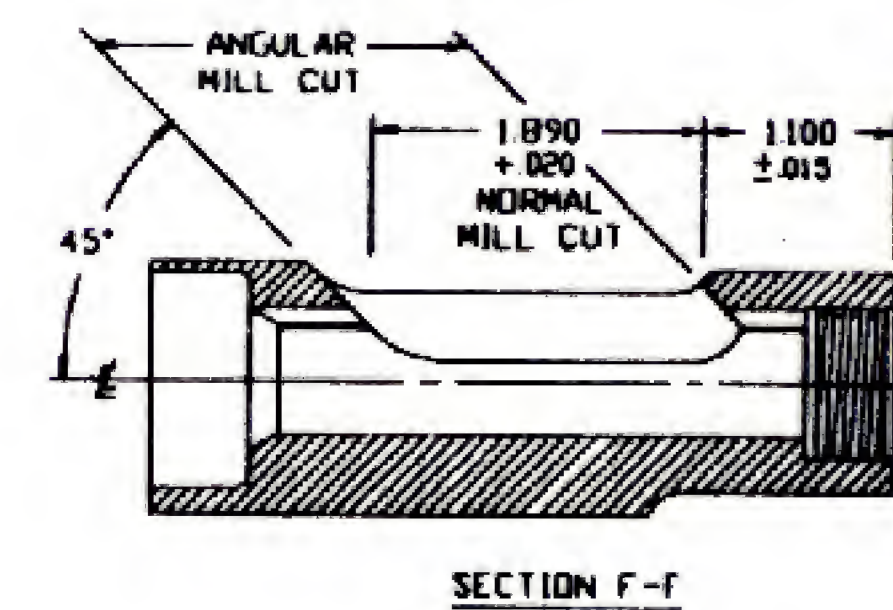
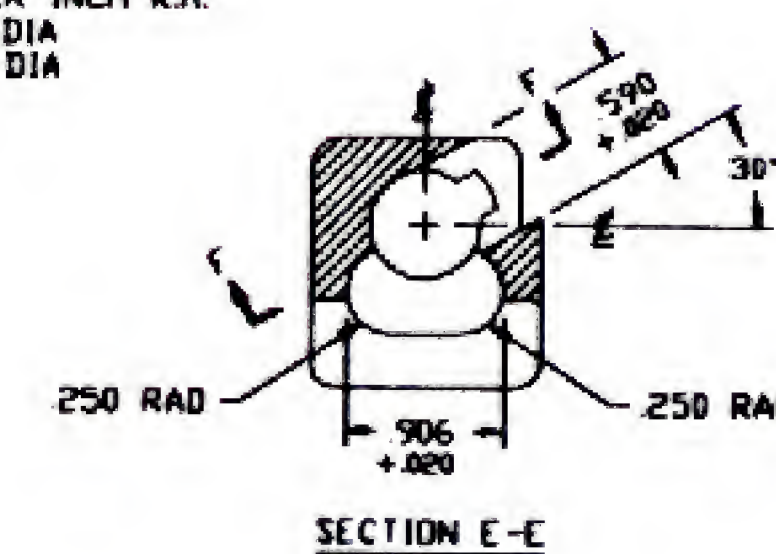
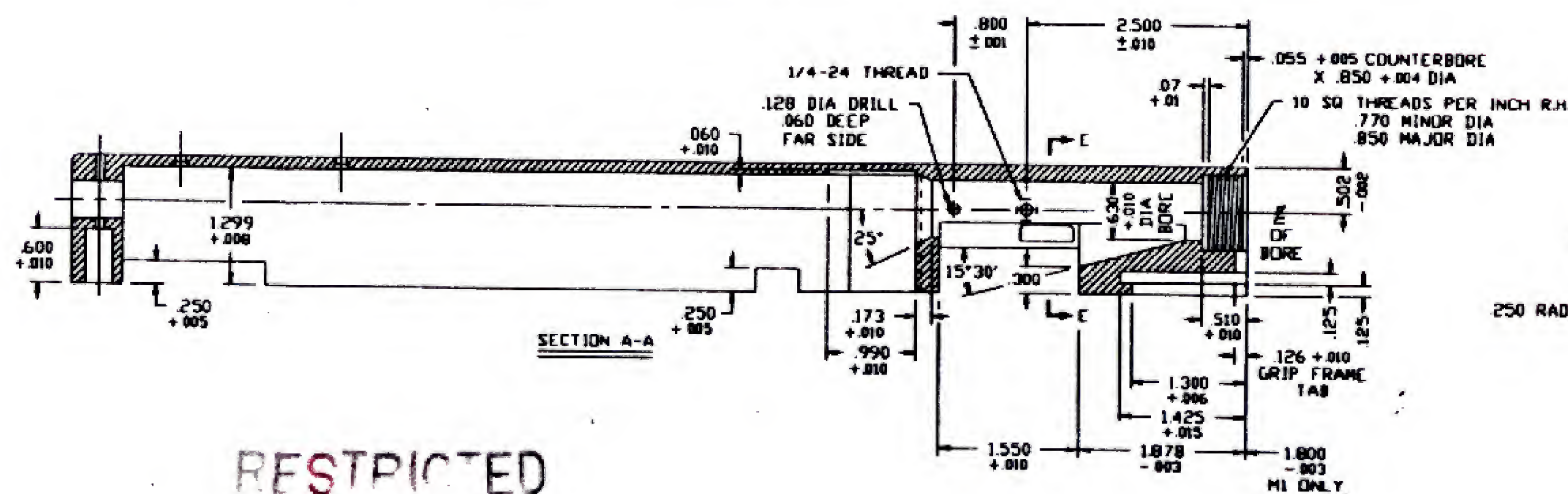
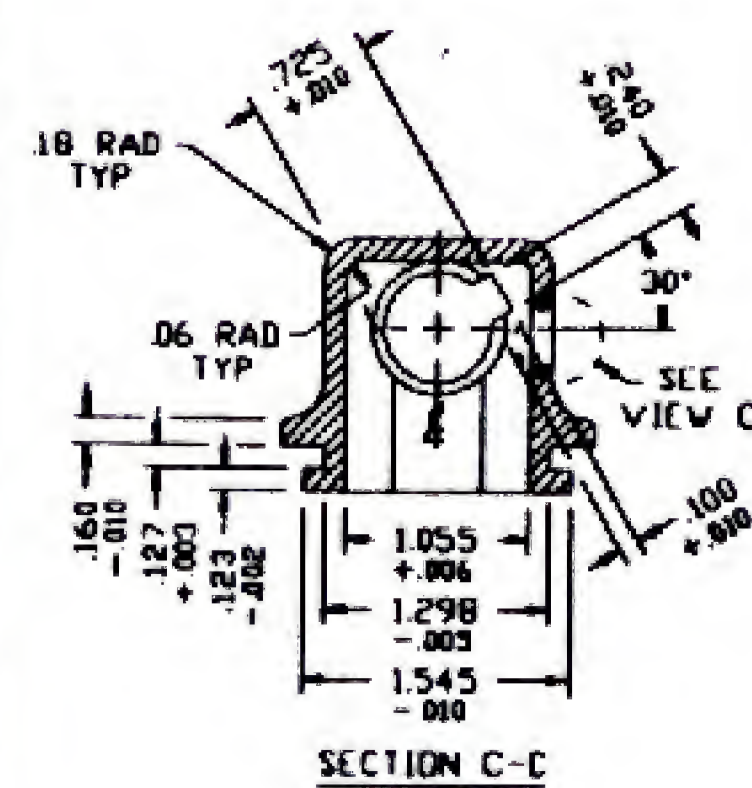
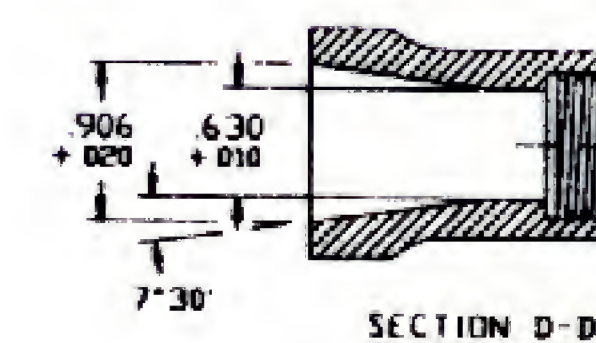
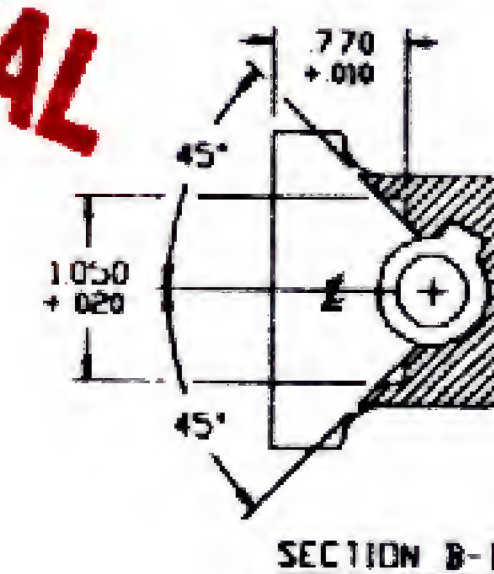
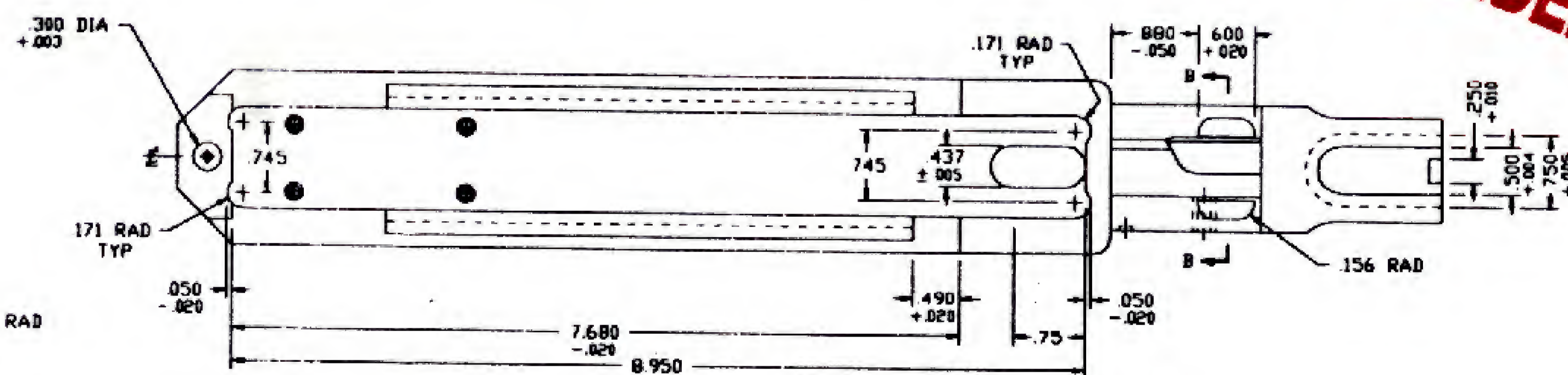
PARTS SUPPLIERS ON LAST PAGE



- NOTES
1. MATERIAL - FS1340, FS2330 (FED SPEC QQ-S-624)
 2. FINISH - TYPE II CLASS A (SPEC USA S7-0-2)
 3. HARDNESS - ROCKWELL A615-70.5
 4. HEAT TREATMENT - HEAT 1350° LEAD POWDER
OIL IN NOTCHES, COOL
REHEAT 1350° 1.5 MIN
OIL QUENCH, DRAW 930°

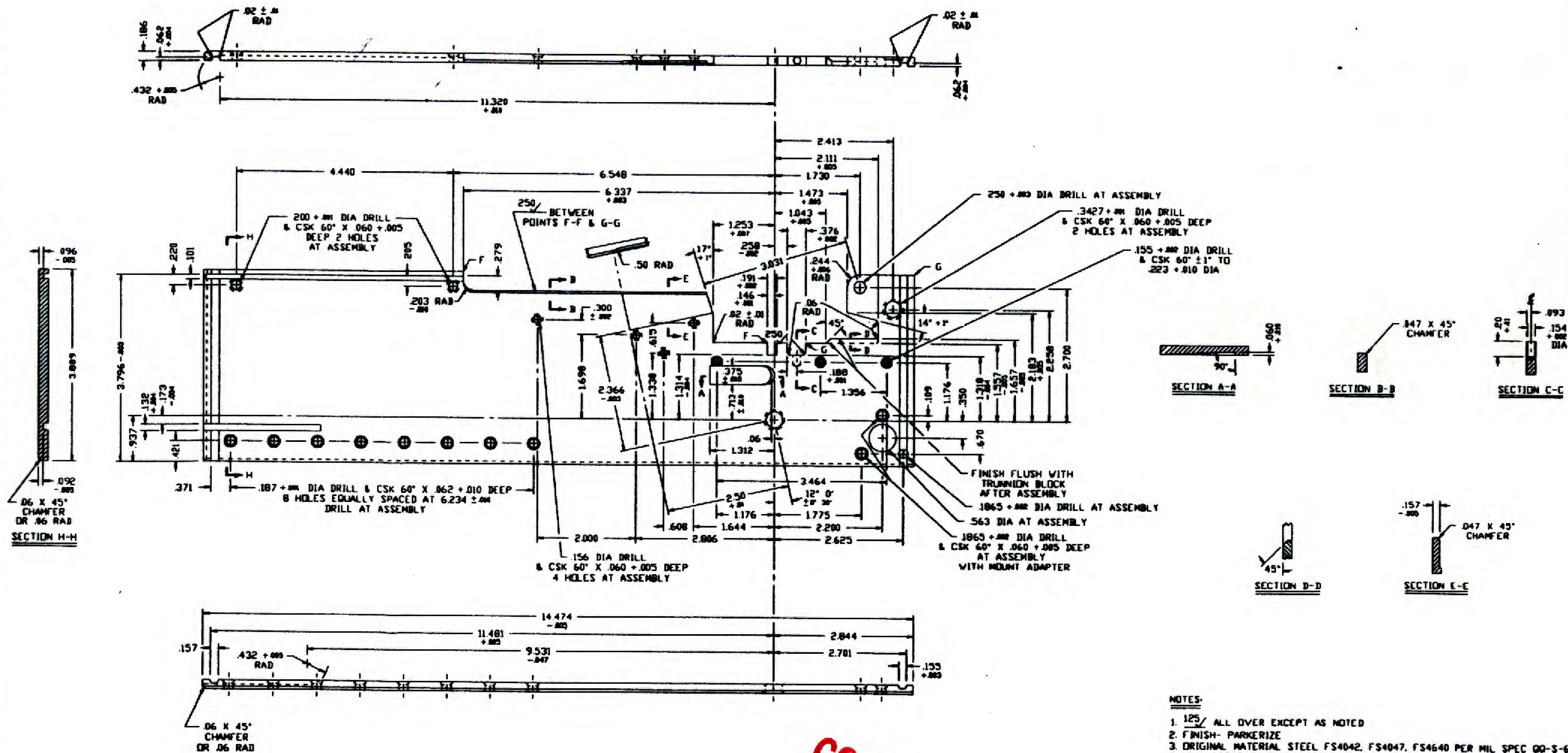


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SCALE: FULL	MATERIAL: SEE NOTE 1	CHKD:	TOLERANCES:
DWN:	FINISH: SEE NOTE 2	DATE:	DEC. P.L. : .005
TITLE: THOMPSON SUBMACHINE GUN MODEL M1A1	REV:	NO.	DEC. P.L. : .005
			ANGLES : .5°

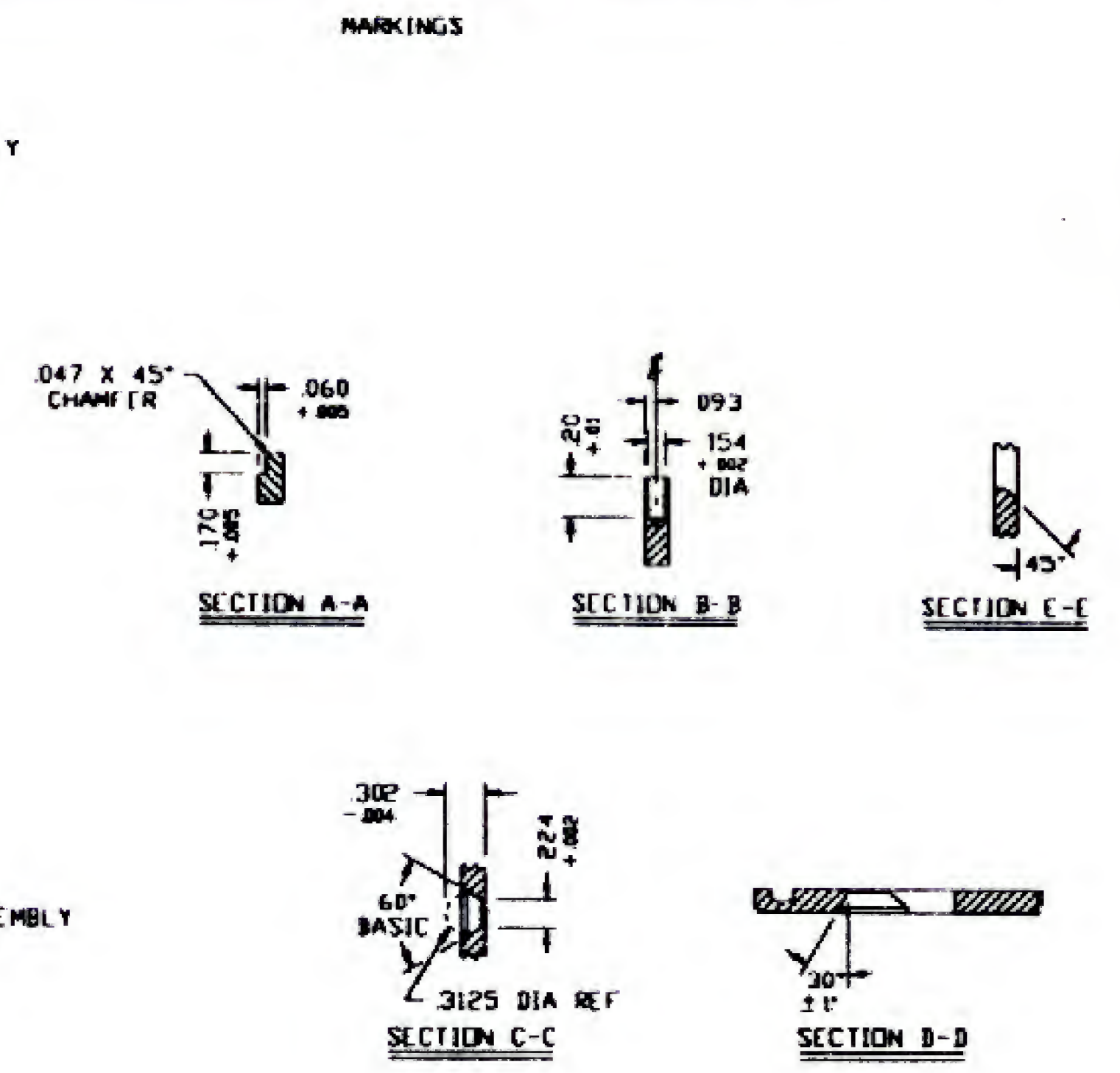
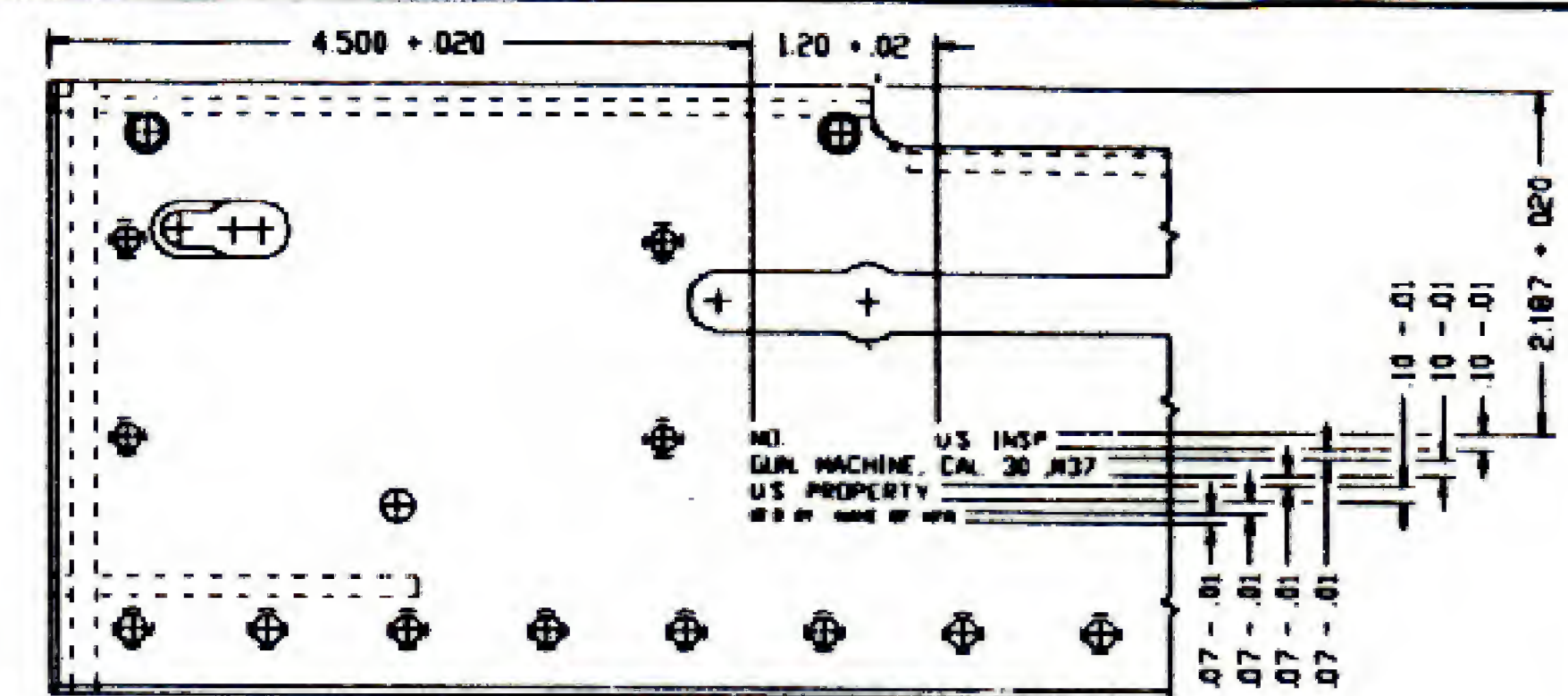
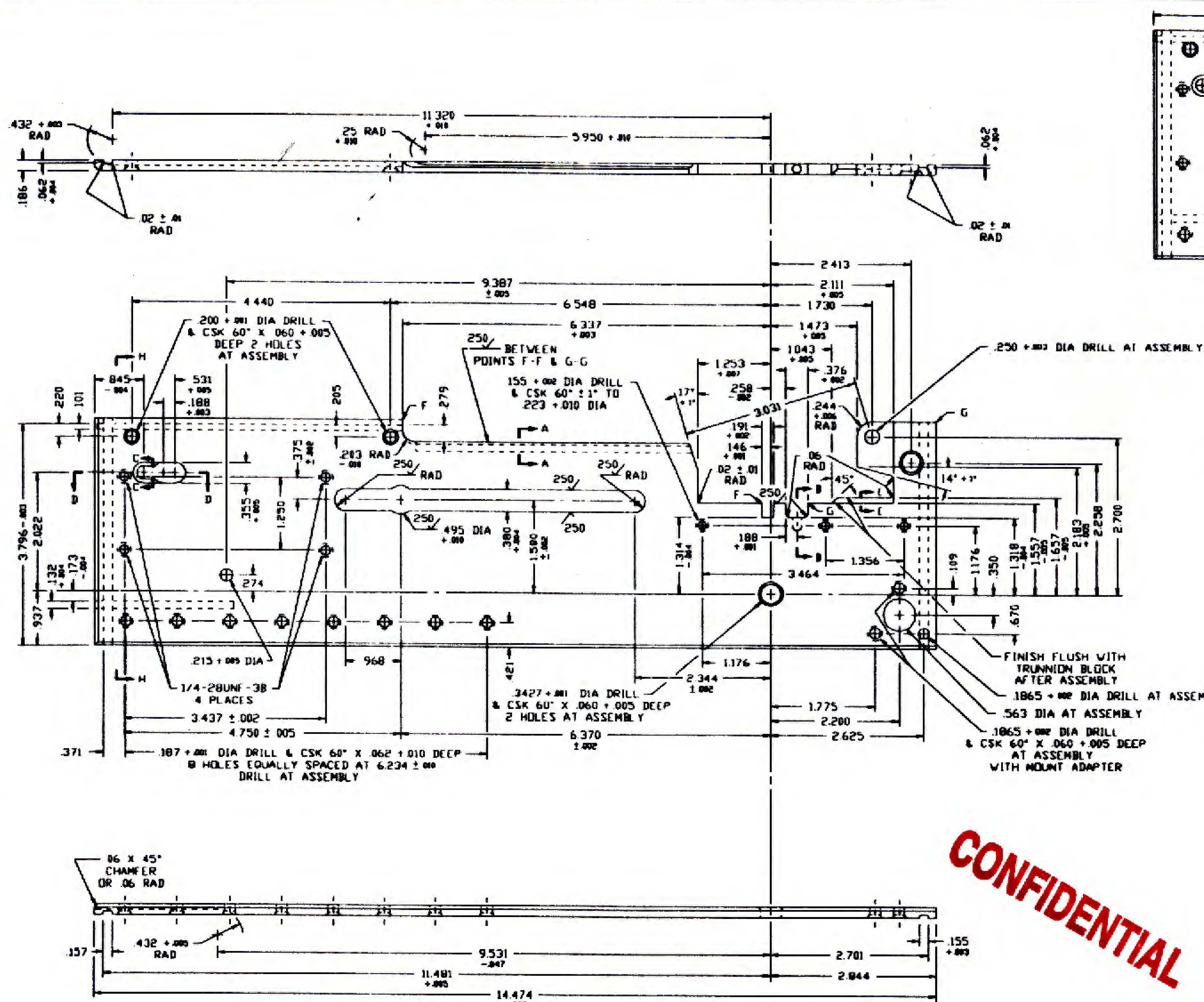


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 MATERIAL

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DRAWN FROM ORD. PART NO. 7100702
 ROCK ISLAND ARSENAL
 DEPT OF THE ARMY
 ROCK ISLAND, ILL.

SCALE	FULL	MATERIAL	SEE NOTE 3	DATE	TOLERANCES
DATE		FINISH	SEE NOTE 2		ALL DIMS ± .005
TITLE	MODEL 37 LEFT HAND SIDE PLATE				ALL DIMS ± .005
REV.					ANGLES ± 5°
NO.					



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- NOTES:
1. 125/ ALL OVER EXCEPT AS NOTED
 2. FINISH- PARKERIZE
 3. ORIGINAL MATERIAL STEEL FS4042, FS4047, FS4640 PER MIL SPEC QQ-S-624
 4. HEAT TREAT REAR END FOR ONE INCH ROCKWELL 'C'43-49 ANNEAL AROUND FOUR HOLES.

RESTRICTED MATERIAL

DRAWN FROM DRD PART NO. 0414730
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL.

SCALE	FULL	MATERIAL	SEE NOTE 3	CAD	DATE	TOLERANCES
DATE		FINISH	SEE NOTE 2			ALL DIMS ± .005
TITLE	MODEL 37 RIGHT HAND SIDE PLATE					ALL DIMS ± .005
REV.						ANGLES ± 5°
NO.						

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**

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1- scale print of THOMPSON 1928-A1 upper

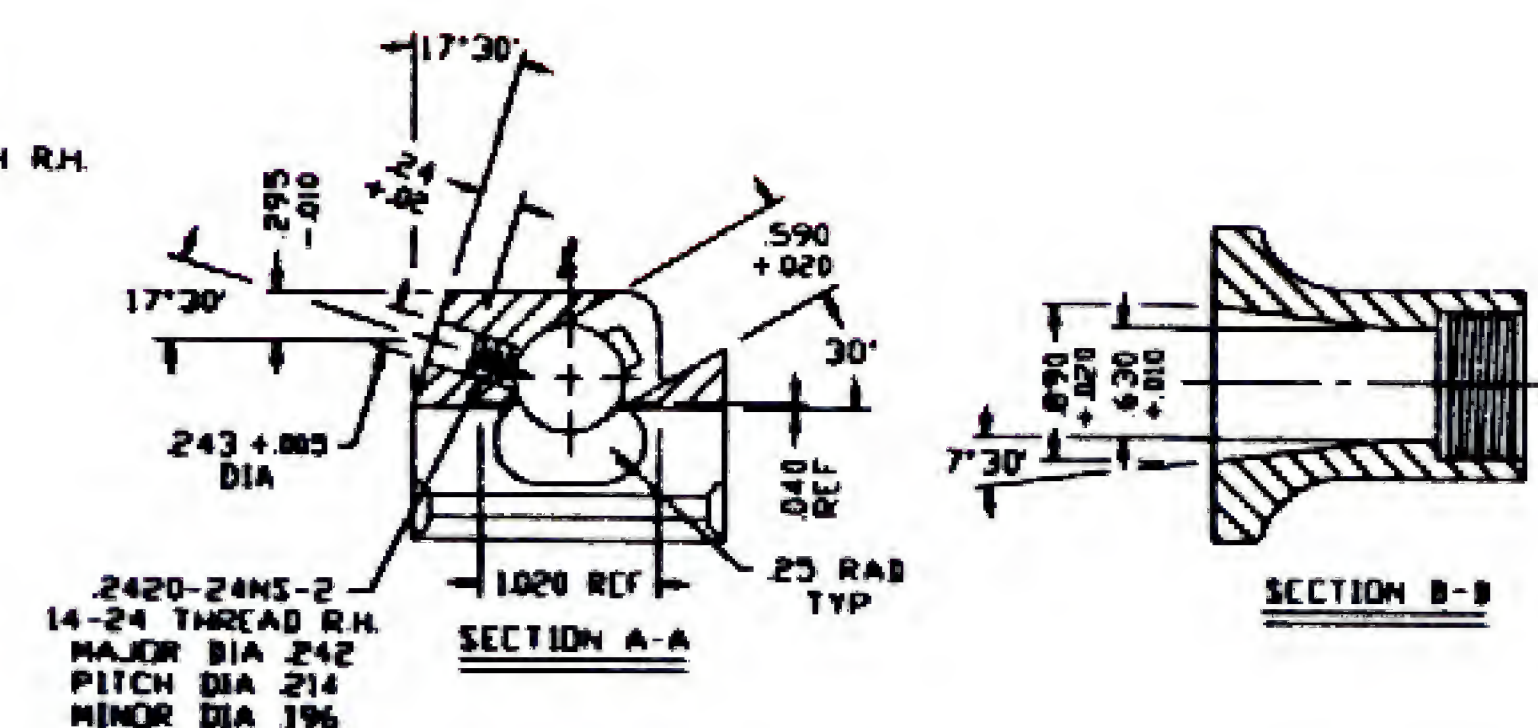
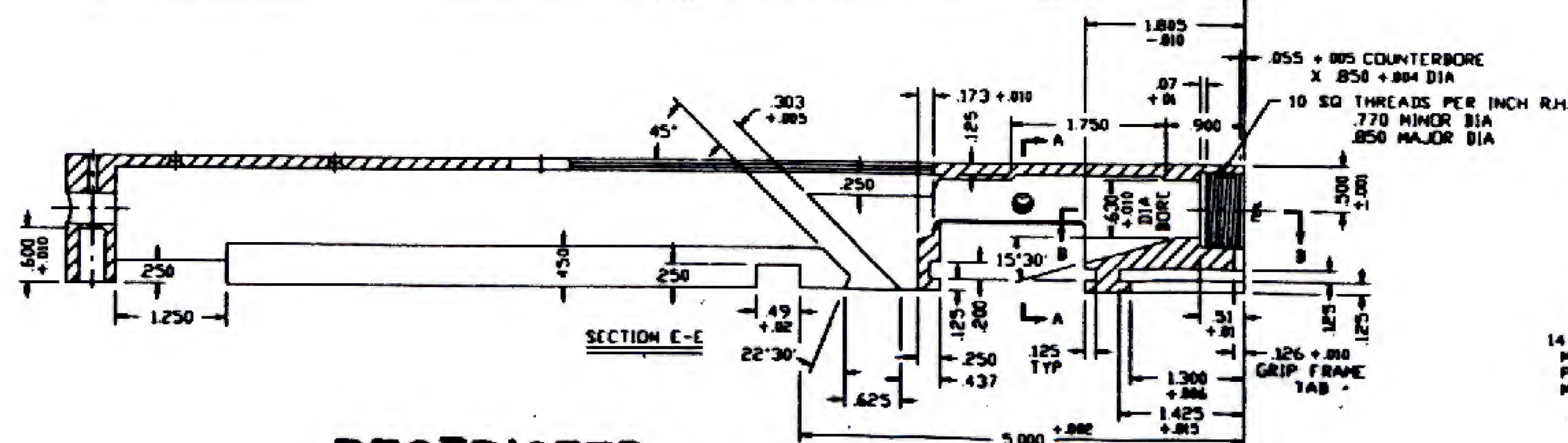
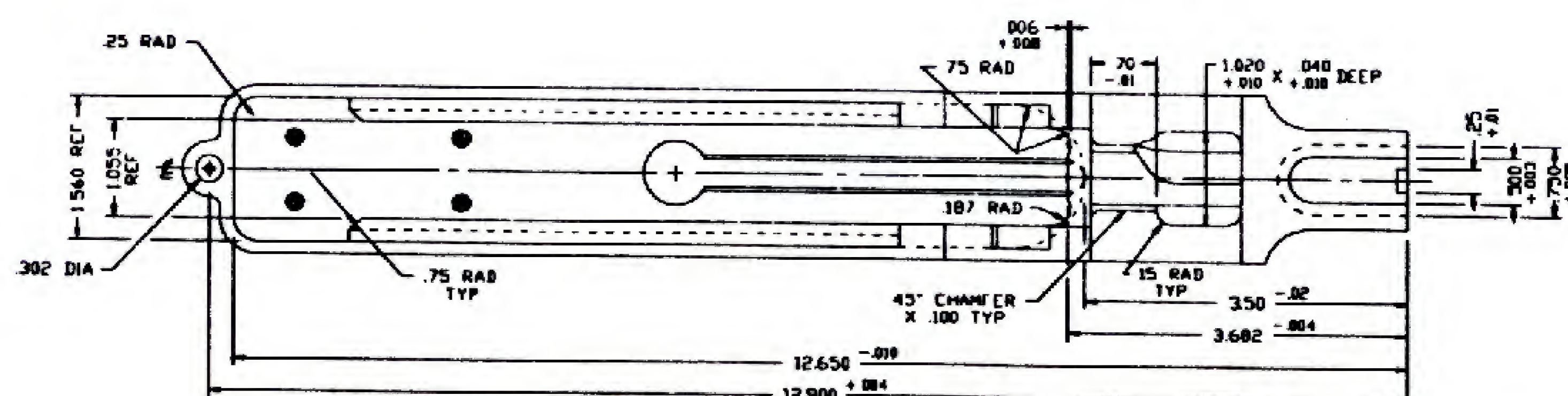
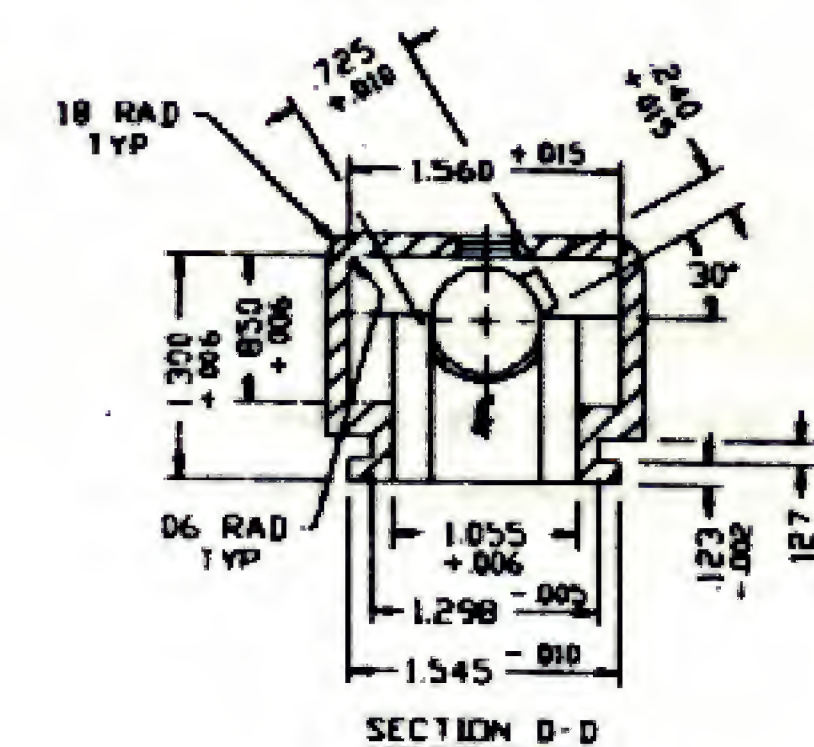
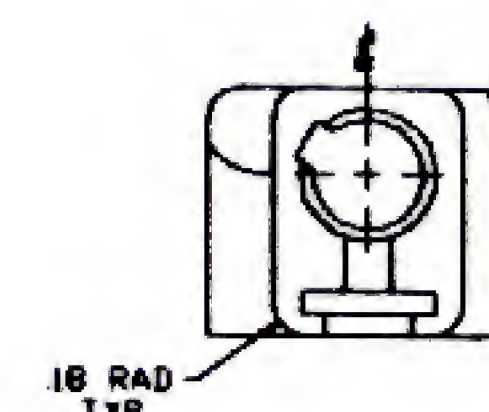
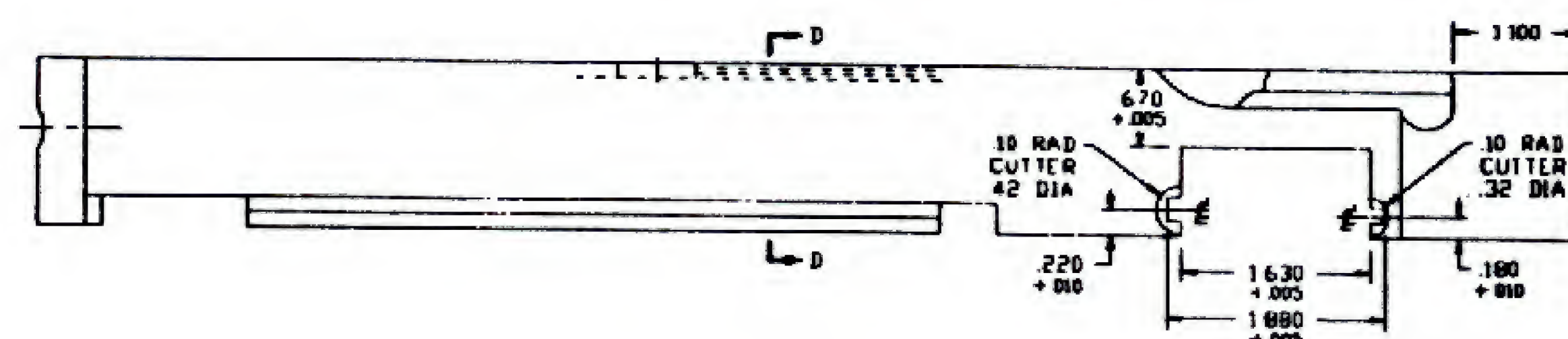
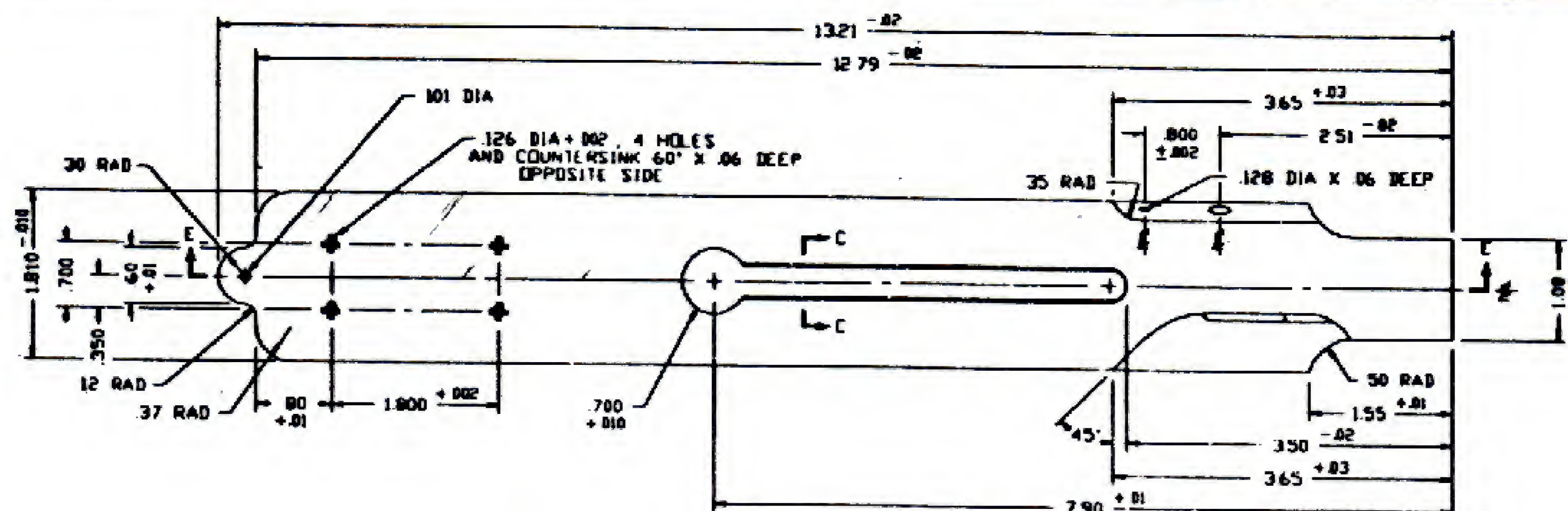
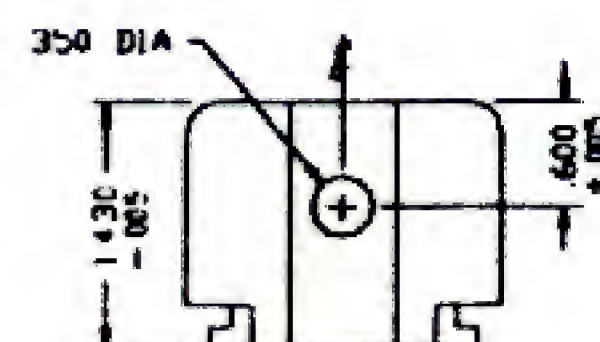
1- scale print of THOMPSON 1928 trigger frame

1- scale print of MP-38

1- scale print of BROWNING BAR AUTOMATIC

1- scale print of VICKERS right side plate

PARTS SUPPLIERS ON LAST PAGE



RESTRICTED
MATERIAL

GENERAL NOTES AND SUGGESTIONS

1. MATERIAL - 1018-4130 STEEL.
2. FINISH- PAKERIZE FOR ALL A-1'S
BLUE FOR 2B COMMERCIAL
BUT BY ALL MEANS SUIT YOURSELF.
3. BREAK ALL SHARP EDGES
4. INSTEAD OF 126 RIVET HOLES I SUGGEST
DRILL 8 43 AND TAP 8 4-40 THREADS
AND ATTACH REAR SIGHT WITH BUTTON SOCKET CAP SCREWS
5. FOR LETTERING ALFER TO THE THOMPSON SUBMACHINE
GUN BY ROGER COX.
6. CORRECTED FROM 1957 ORDNANCE PRINT WITH CORRECT
DIMENSIONS OF A 1928 THOMPSON RECEIVER.

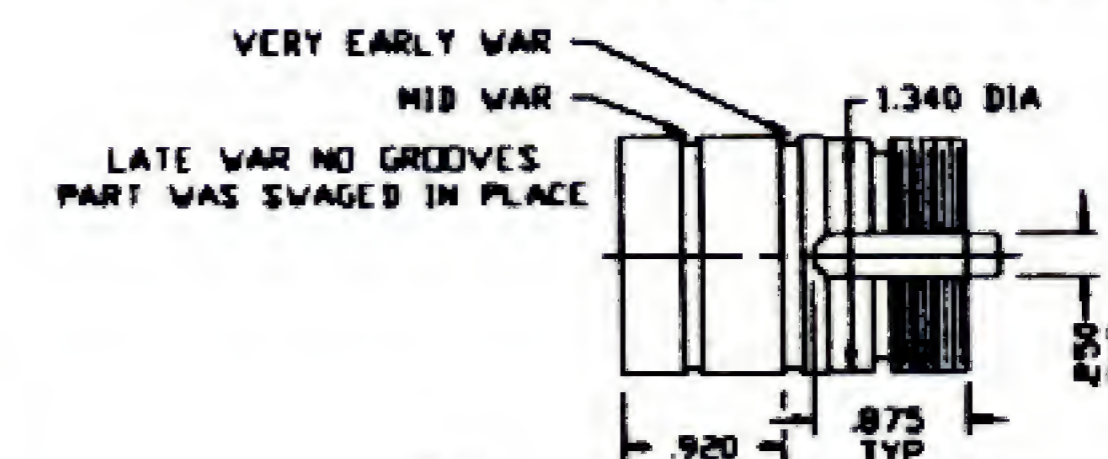
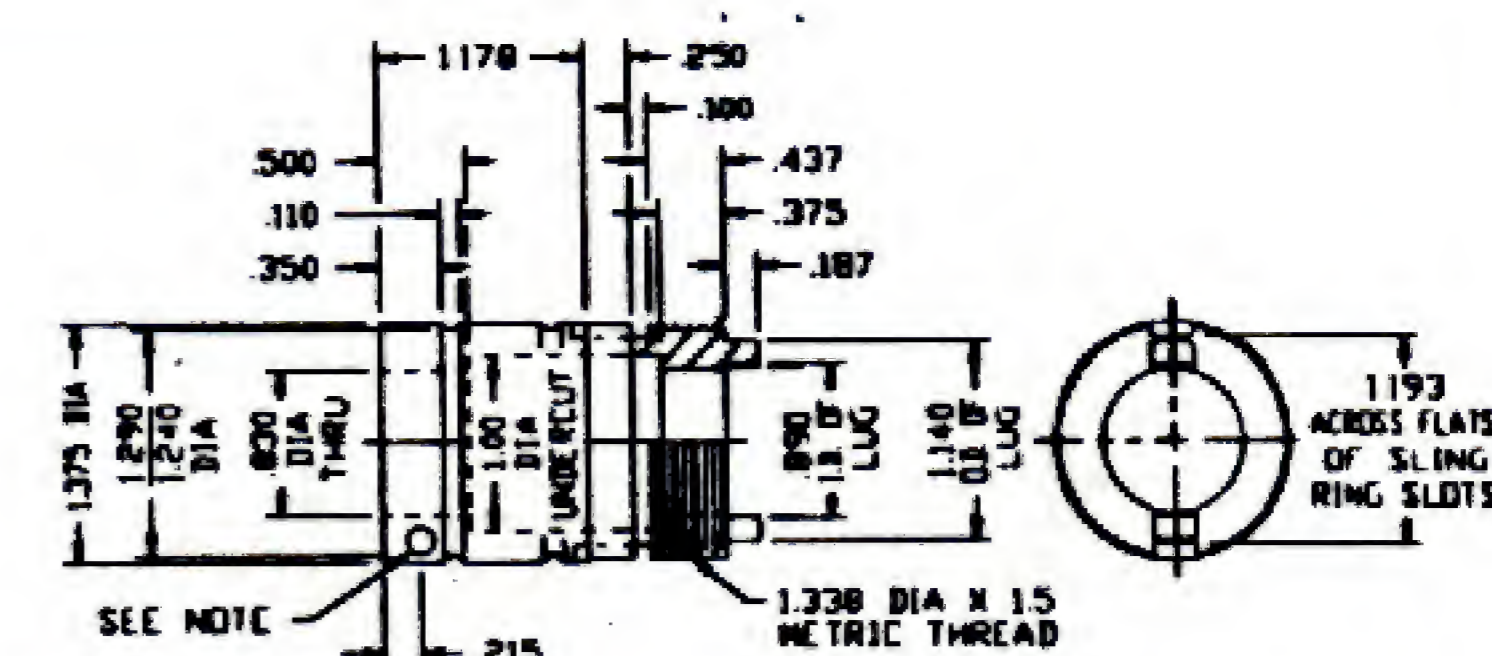
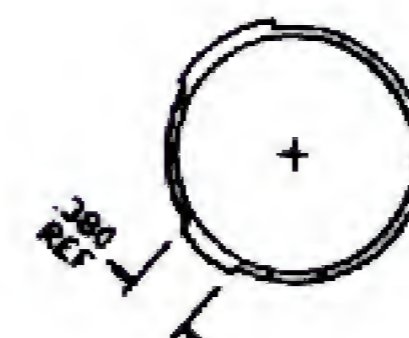
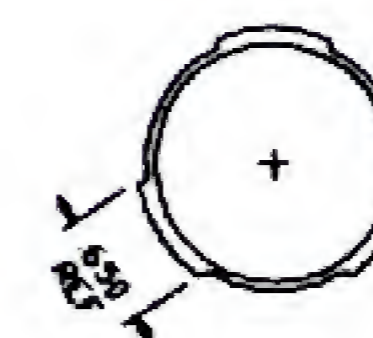
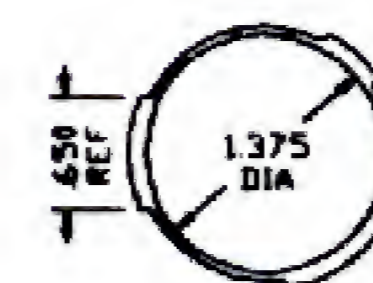
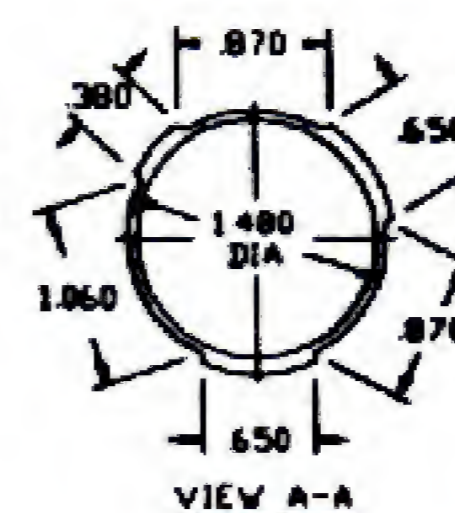
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Photo	FILED IN: SEE NOTE 2	DATE	
TITLE		REV.	
THOMPSON SUBMACHINE GUN RECEIVER MODEL 1928-A1			002



**RESTRICTED
MATERIAL**

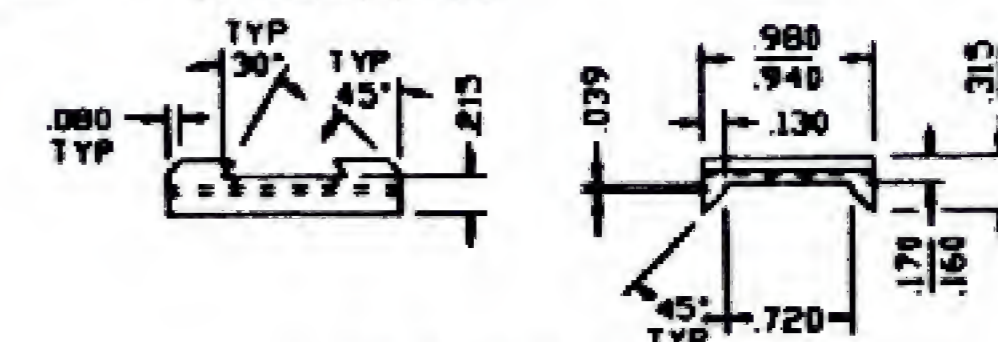
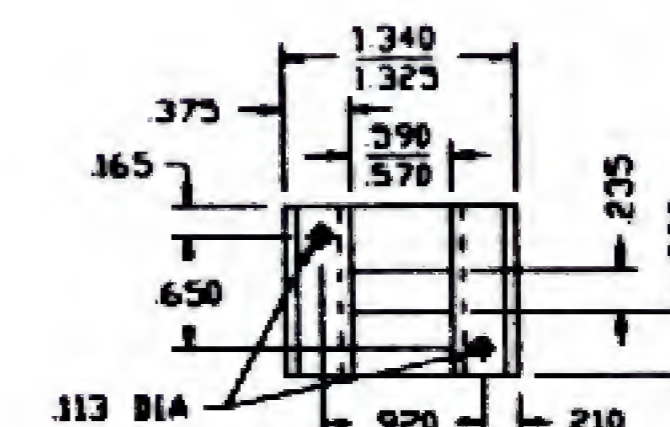
NOTE:
1. MATERIAL - 1018-4130 STEEL

SCALE: FULL	MATERIAL: SEE NOTE 1	CAD	TOLERANCES: DEC IN 2 PL. ± .01 IN 3 PL. ± .005 ANGLES ± .0°
QUAN	FINISH	DATE	REV.
TITLE: MODEL 1928 THOMPSON SUBMACHINE GUN TRIGGER FRAME		REV.	NO.

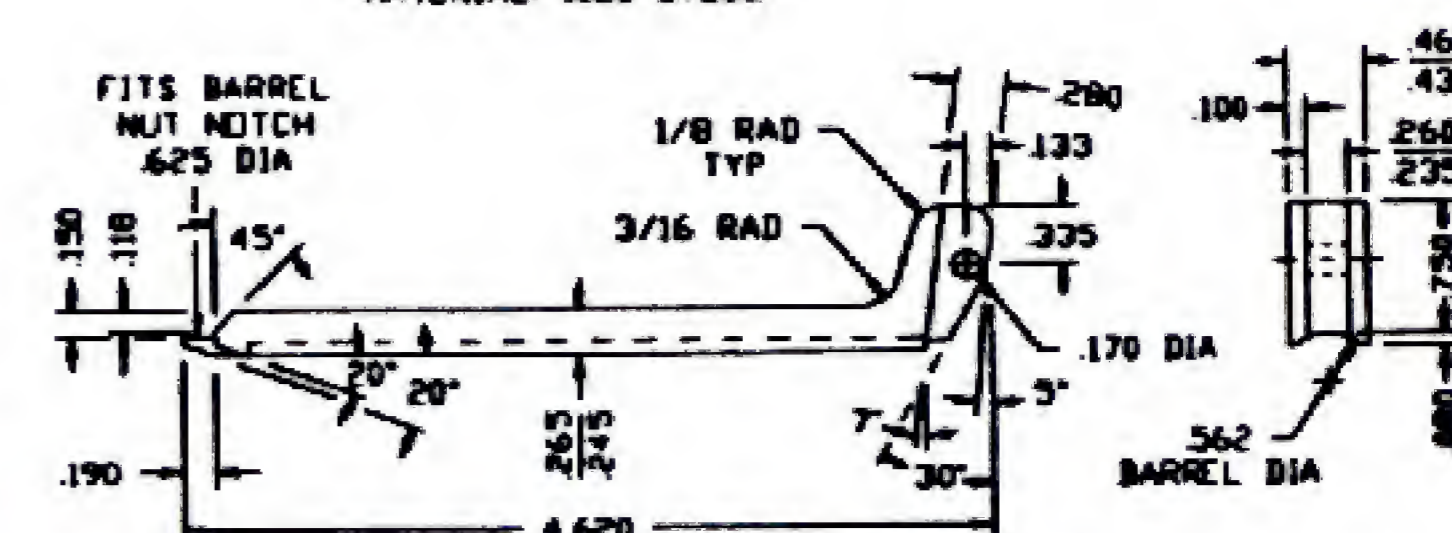


NOTE:
HOLE IN MAGAZINE HOUSING IS THE FACTOR WHEN ASSEMBLED
CROSS HOLE CHECKS ABOUT .215 THIS IS THE LAST HOLE
TO DRILL AND AT ASSEMBLY.

BARREL BUSHING
MATERIAL: 1020 STEEL



REAR SIGHT BASE
MATERIAL: 1020 STEEL



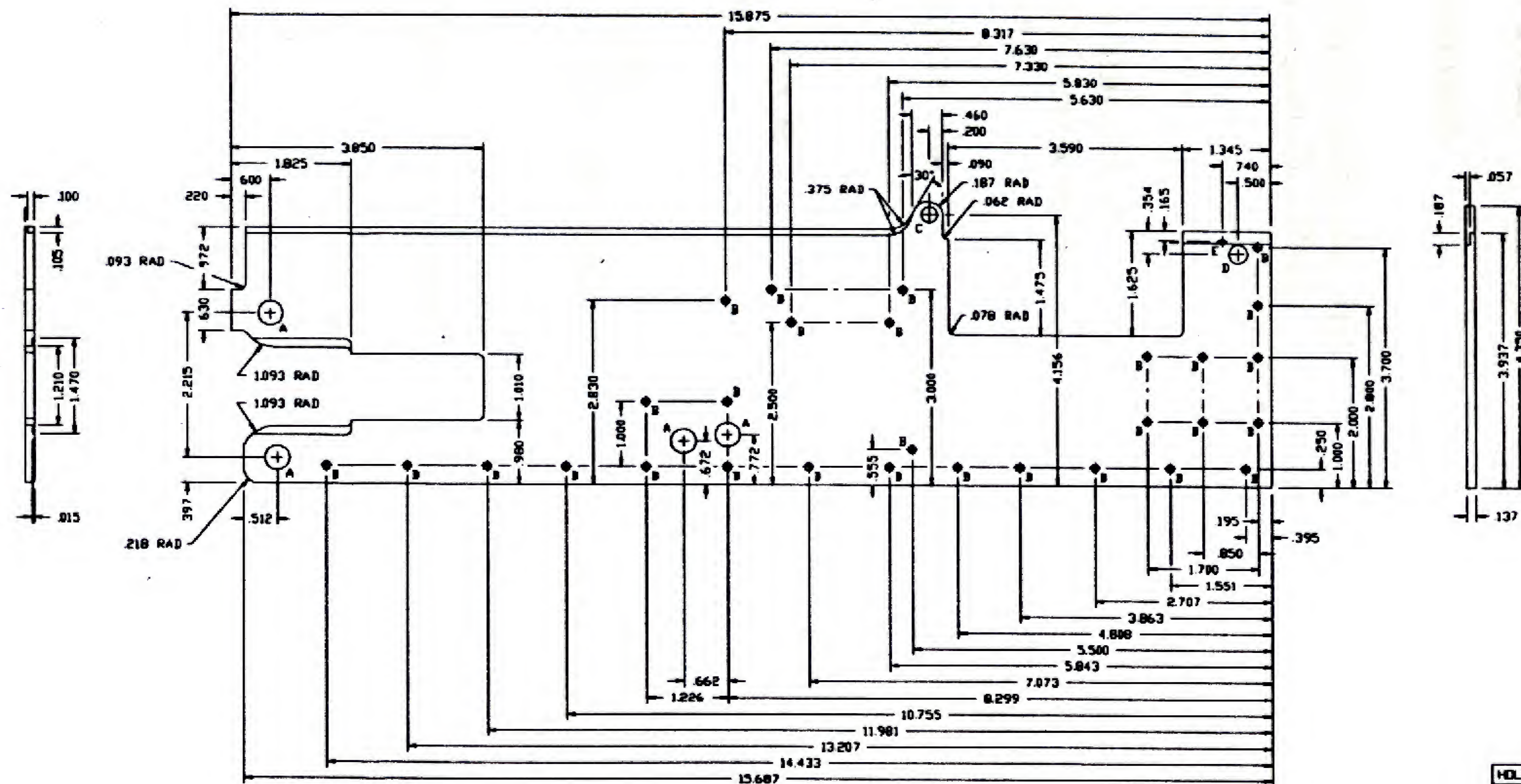
EARLY GUNS MATERIAL WAS ALUMINUM
FEW WERE STAMPED SHEET STEEL
LATE GUNS MATERIAL WAS BAKELITE OR SIMILAR

RESTING BAR

RESTRICTED
MATE

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SCALE: FULL	INTERNAL: SEE NOTE 1	FILE	TOLERANCES
DATA	FINISH: SEE NOTE 2	DATE	SEC 1 PM 2 25
TITLE: MP-38 RECEIVER		REV.	SEC 3 PM 2 25
			ANGLES 2 25
			NO.



NOTES:

1. MATERIAL- 4130, 4140, 4340 - PRE HEAT TREAT 28-32 R/C
2. FINISH- BLUE
3. ALL #30 DRILLED HOLES ARE FOR .125 DIA RIVETS

DRILL CHART

NO.	DESCRIPTION	QTY
A	.375 DIA	4
B	.125 DIA (#30 DRILL)	29
C	.250 DIA	1
D	.290 DIA	1
E	.082 DIA (#45 DRILL)	1

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MATERIAL

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SCALE	DATE	REV.	TOLERANCES
FULL	SEE NOTE 1		DECIMALS
	SEE NOTE 2		INCHES
TITLE	VICKERS RIGHT SIDE PLATE		ANGLES 1/8"

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**

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1- scale print of MK V sten

1- scale print of MAC 10 upper

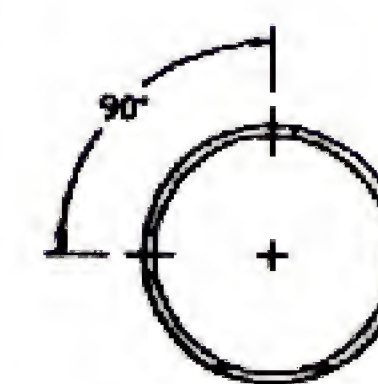
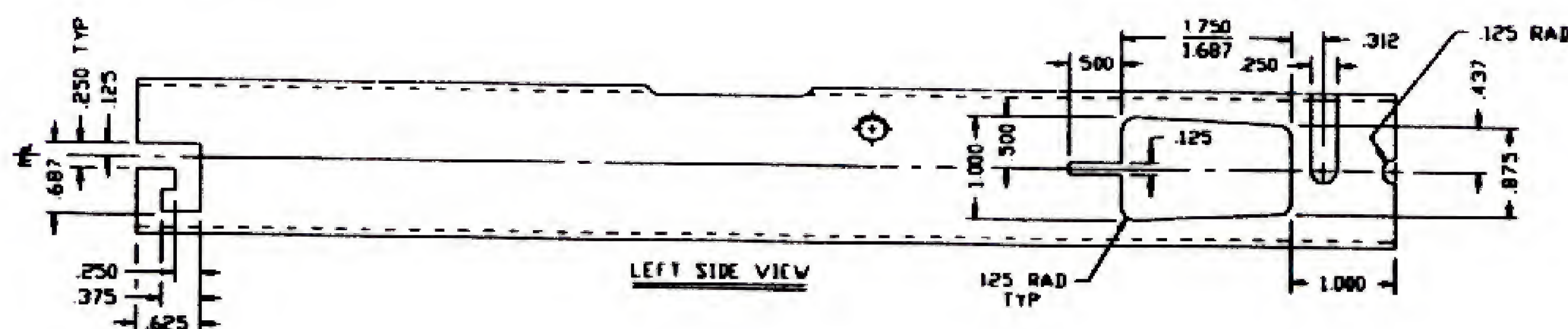
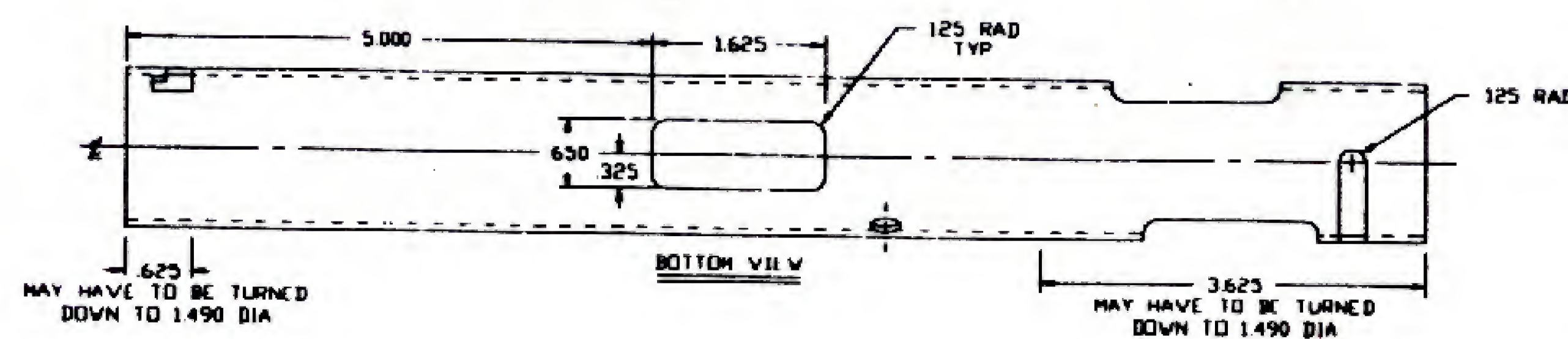
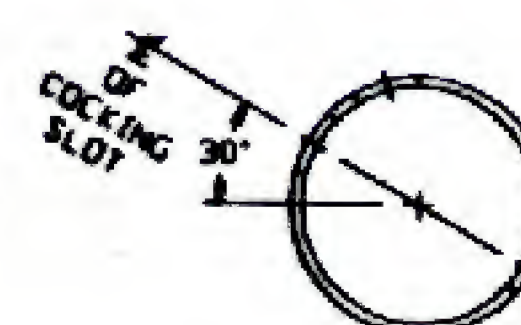
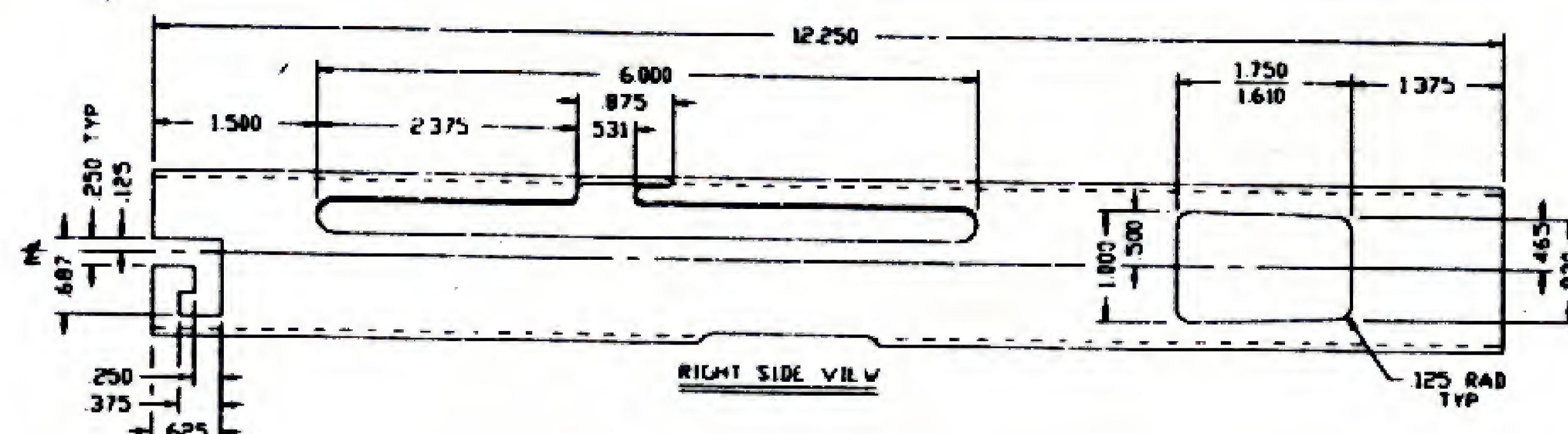
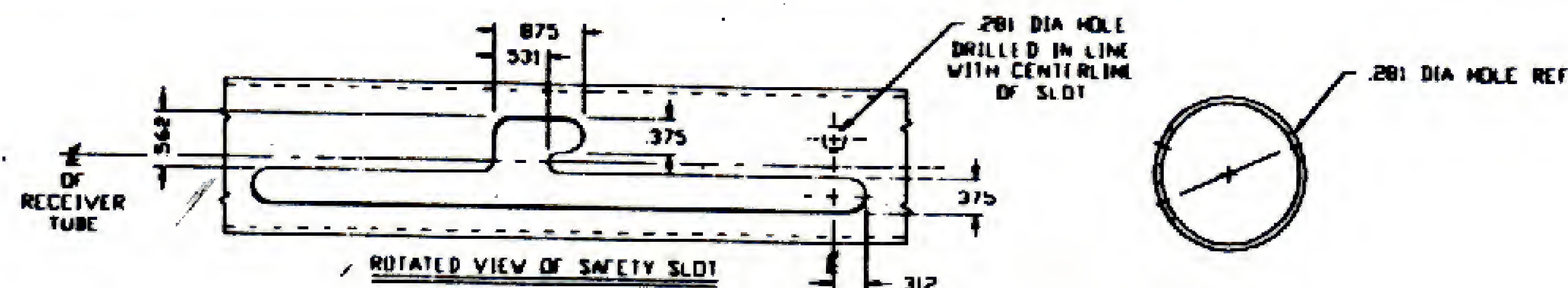
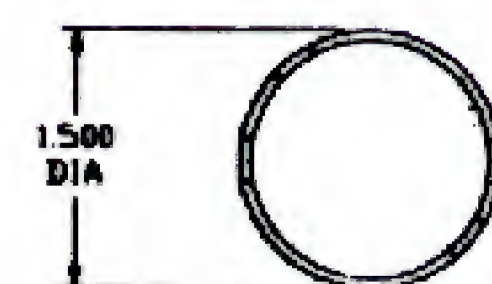
1- scale print of MAC 10 lower

1- scale print of AUSTIN MK I

1- scale print of BERETTA 38A AND 38/44

1- scale print of MADSEN MODEL 1950

PARTS SUPPLIERS ON LAST PAGE

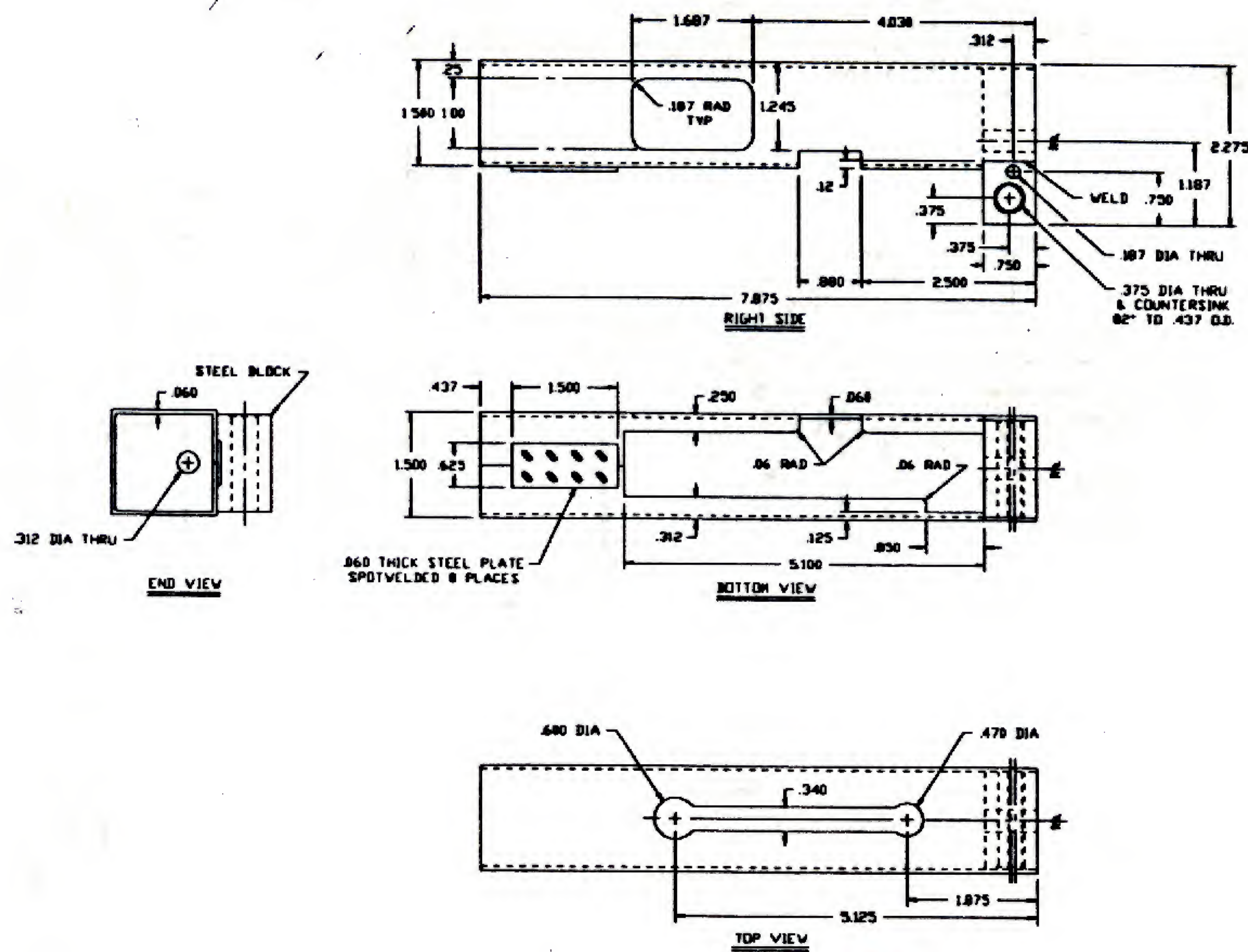


- NOTES**
- 1 MATERIAL - MILD STEEL SEAMLESS, DRAWN OVER MANDREL 1.500 O.D X .049, .055, .062 WALL.
 - 2 FINISH - PAINT BLACK.
 - 3 SHORTCUT TO CONSTRUCTION CAN BE ACCOMPLISHED BY CUTTING TUBE FLUSH TO REAR SIGHT RING AND FLUSH TO BARREL BUSHING IF THIS METHOD IS USED, A REDUCTION IN LENGTH MUST ALSO BE MADE.
 - 4 625 AND 3.625 DIMENSIONS MAY NEED TO BE TURNED DOWN TO 1.490 DIA TO FIT MAGAZINE HOUSING AND REAR SIGHT RING.

RESTRICTED MATERIAL

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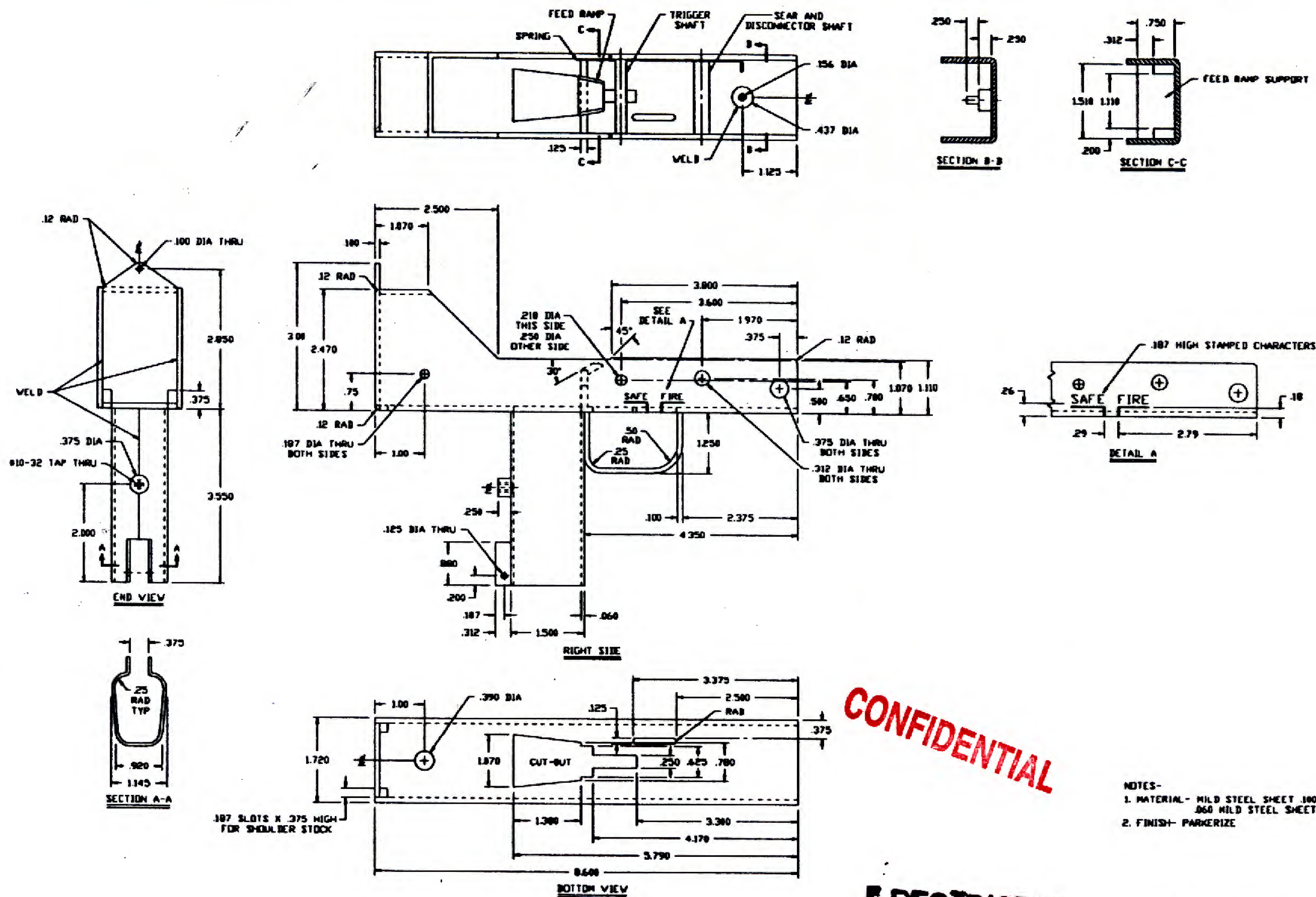
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MATERIAL

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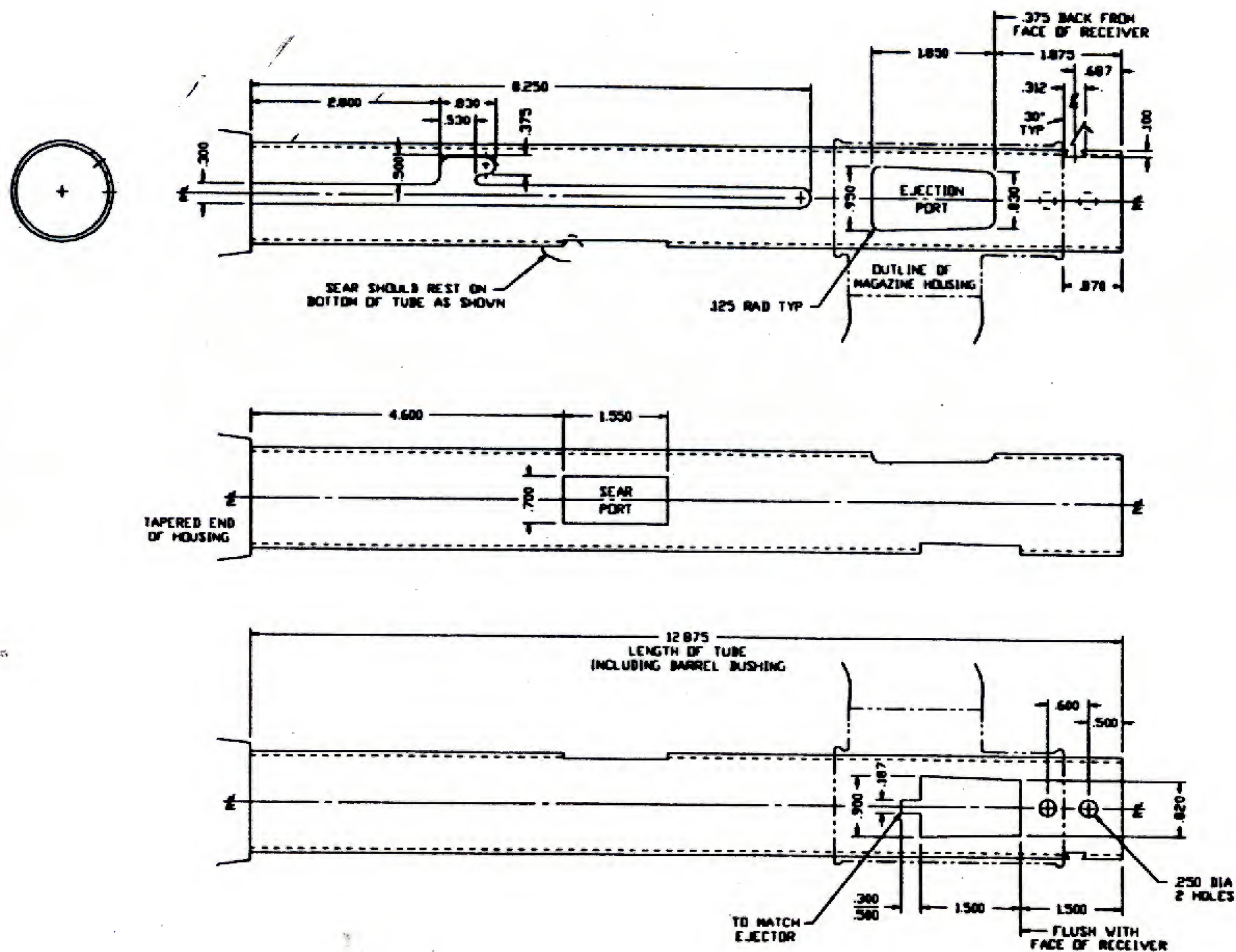
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		SEE NOTE 1		REV. 1
DATE		SEE NOTE 2		REV. 2
FILE	PAC-90 UPPER RECEIVER			REV. 3



NOTES-

1. MATERIAL- MILD STEEL SHEET .100 THICK
 .060 MILD STEEL SHEET WHERE NOTED

2. FINISH- PARKERIZE

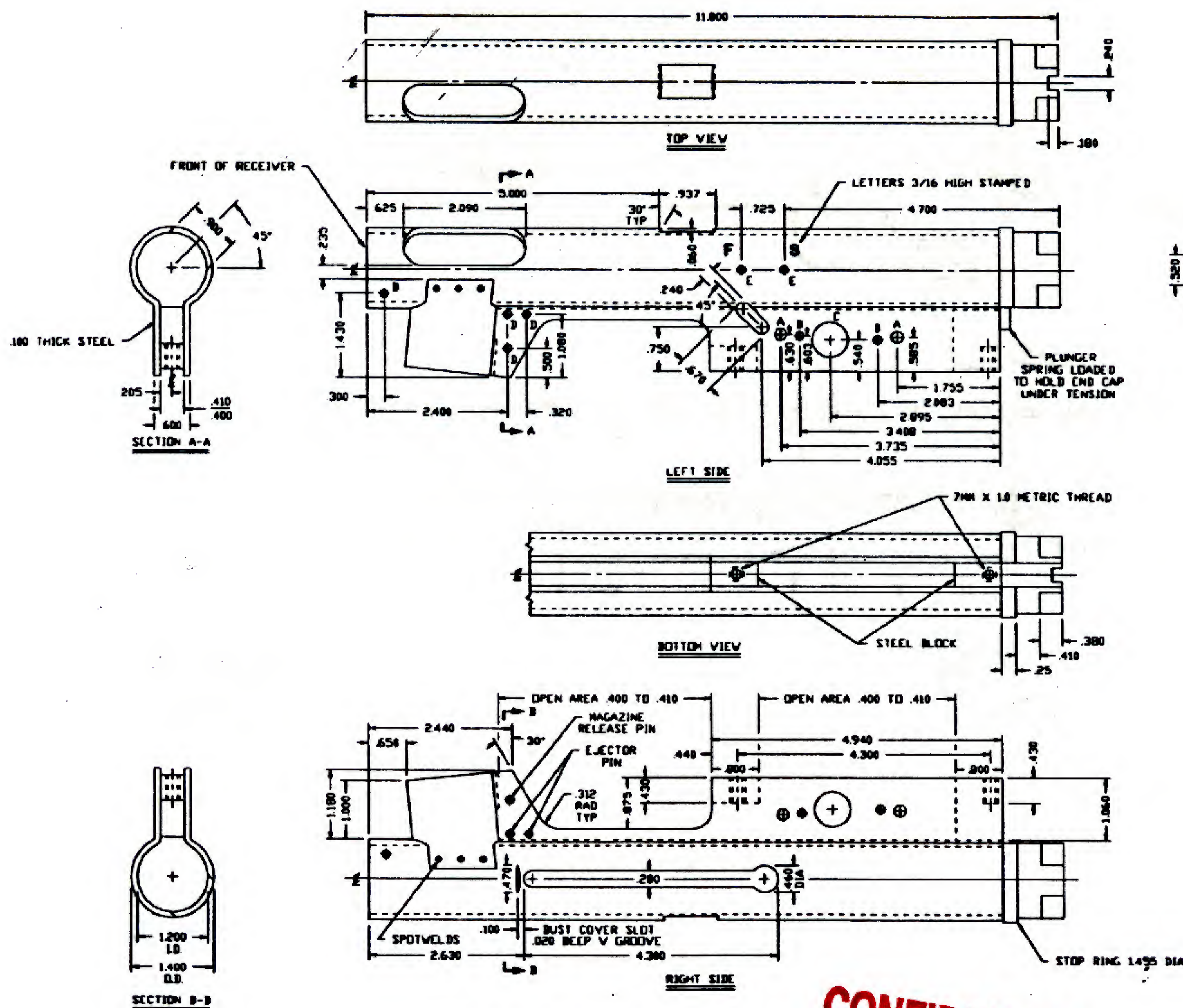


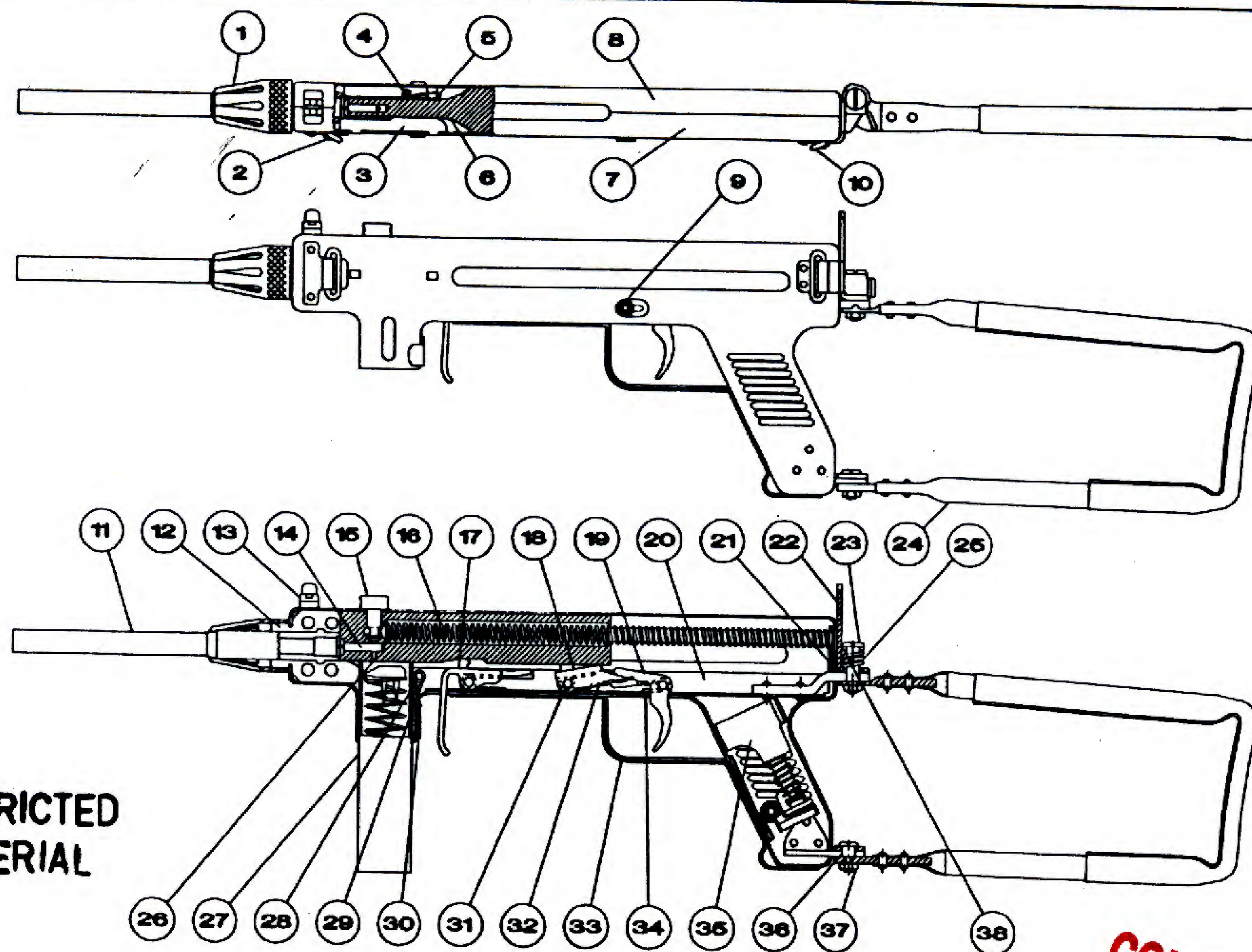
- NOTES:
 1. MATERIAL- 1.500 O.D. X .065 WALL D.D.M. STEEL TUBE
 2. FINISH- PARKERIZE AND PAINT FLAT BLACK

RESTRICTED
MATERIAL

CONFIDENTIAL

READ FULL	INTERNAL SEE NOTE 1	CHK	VERIFIED
DATE	FORM SEE NOTE 2	DATE	DATE
TITLE	AUSTEN MK I RECEIVER	REV.	REV.





**RESTRICTED
MATERIAL**

CONFIDENTIAL

MADSEN MODEL 1950 SUBMACHINE GUN

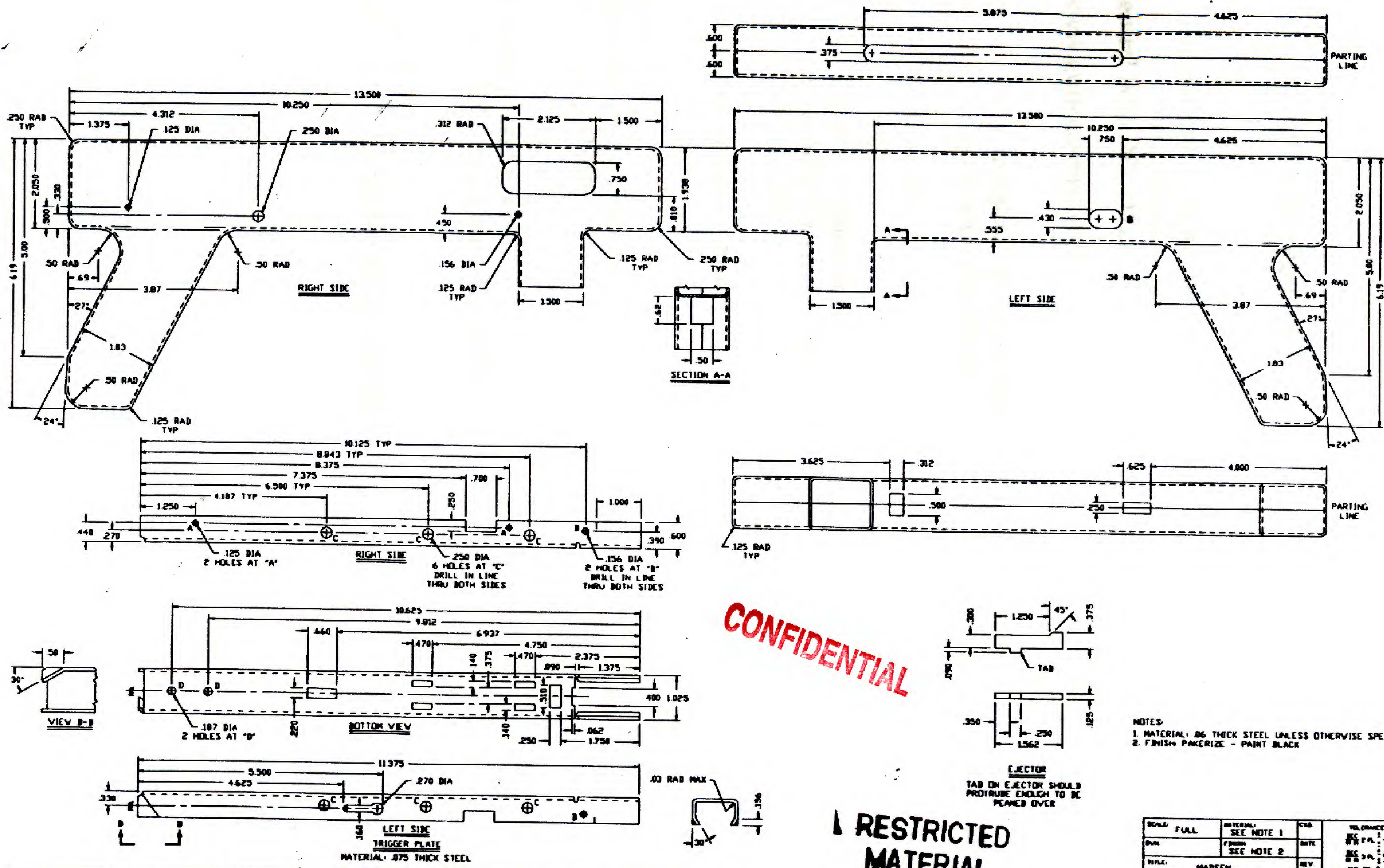
1 BARREL BEARING NUT
2 SLING SWIVEL
3 EJECTOR
4 EXTRACTOR PIN
5 EXTRACTOR
6 BREECHBLOCK
7 FRAME HALF (LEFT)
8 FRAME HALF (RIGHT)
9 SAFETY CATCH
10 SLING SWIVEL

11 BARREL
12 BARREL BEARING
13 FRONT SIGHT
14 FIRING PIN
15 COCKING HANDLE
16 RETURN SPRING
17 BREECH BLOCK RETAINER
18 TRIGGER ROD
19 TRIGGER
20 TRIGGER PLATE

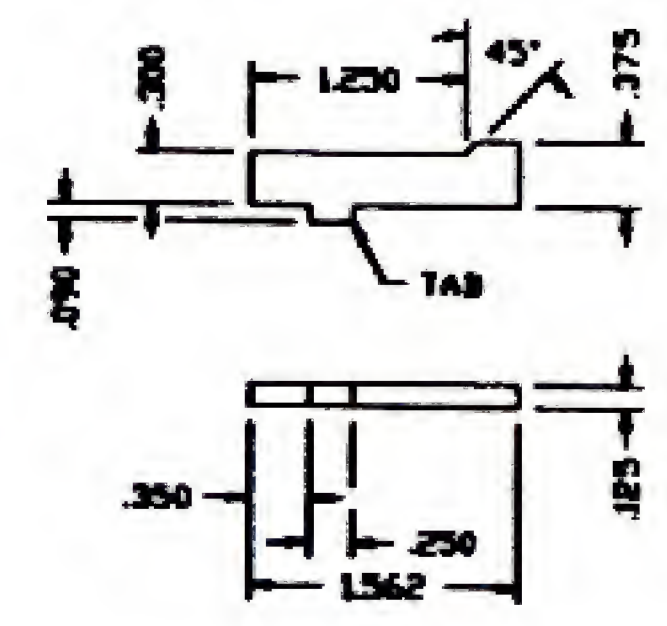
21 RETURN SPRING GUIDE (COMPLETE)
22 REAR SIGHT PLATE
23 SHOULDER PIECE BOLT (UPPER)
24 SHOULDER PIECE
25 SHOULDER PIECE SPRING
26 FIRING PIN RIVET
27 MAGAZINE
28 MAGAZINE CATCH PIN
29 MAGAZINE CATCH SPRING

30 MAGAZINE CATCH
31 TRIGGER ROD PIN
32 TRIGGER ROD SPRING
33 TRIGGER GUARD
34 TRIGGER SPRING
35 MAGAZINE LOADING APPARATUS
36 SHOULDER PIECE BOLT (LOWER)
37 SHOULDER PIECE BOLT NUT
38 SHOULDER PIECE LOCK

SCALE	INTERVAL	DATE	REVISIONS
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NOTES:
 1. MATERIAL: .06 THICK STEEL UNLESS OTHERWISE SPECIFIED
 2. FINISH: PARKERIZE - PAINT BLACK



EJECTOR
 TAB ON EJECTOR SHOULD
 PROTRUDE ENOUGH TO BE
 PLANED OVER

SCALE: FULL	MATERIAL: SEE NOTE 1	CRD	TOLERANCES
DWG	FROM: SEE NOTE 2	DATE	AS SHOWN
TITLE: MADSEN MODEL 50 RECEIVER	REV		UNLESS NOTED

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**

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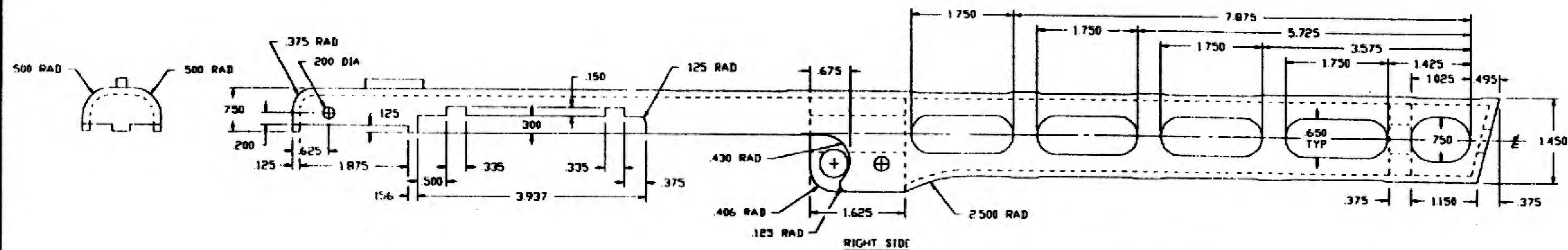
1- scale print of RUSSIAN PPSH-41

1- scale print of YUOGOSLAV 49/57

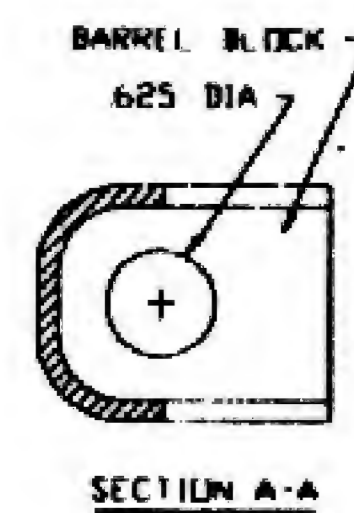
1- scale print of AMERICAN 180

**1- scale print of BROWNING 1919A4/A6
right and left sides**

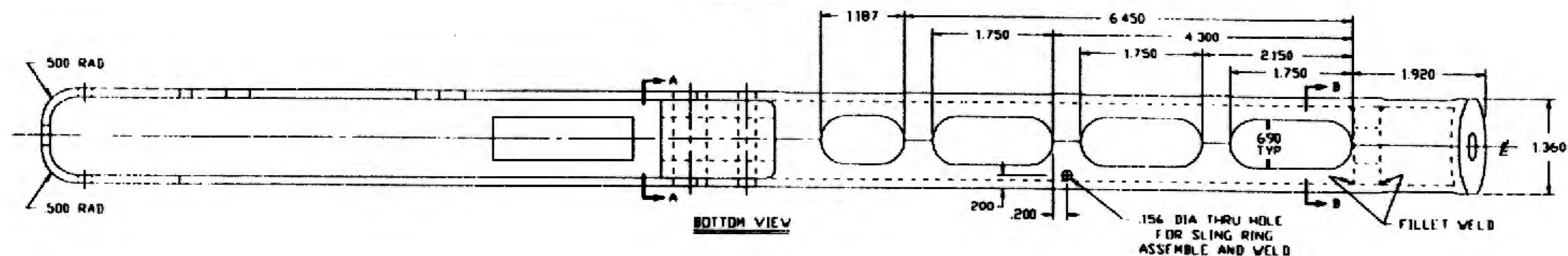
PARTS SUPPLIERS ON LAST PAGE



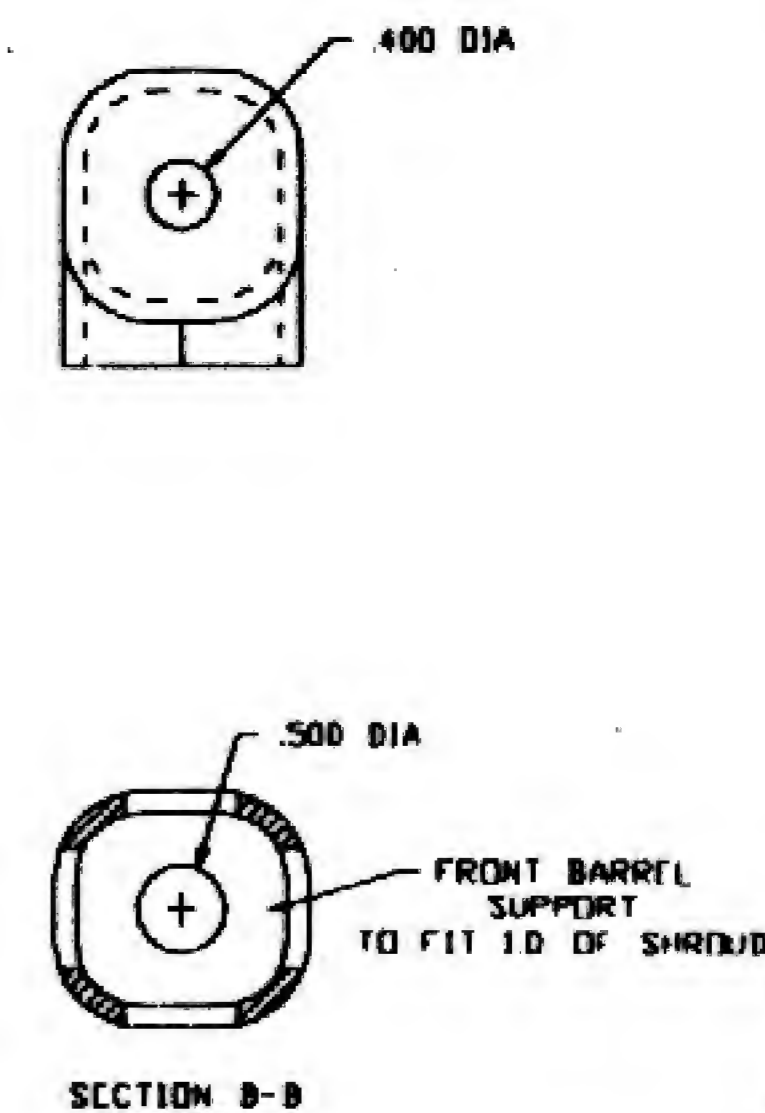
RIGHT SIDE



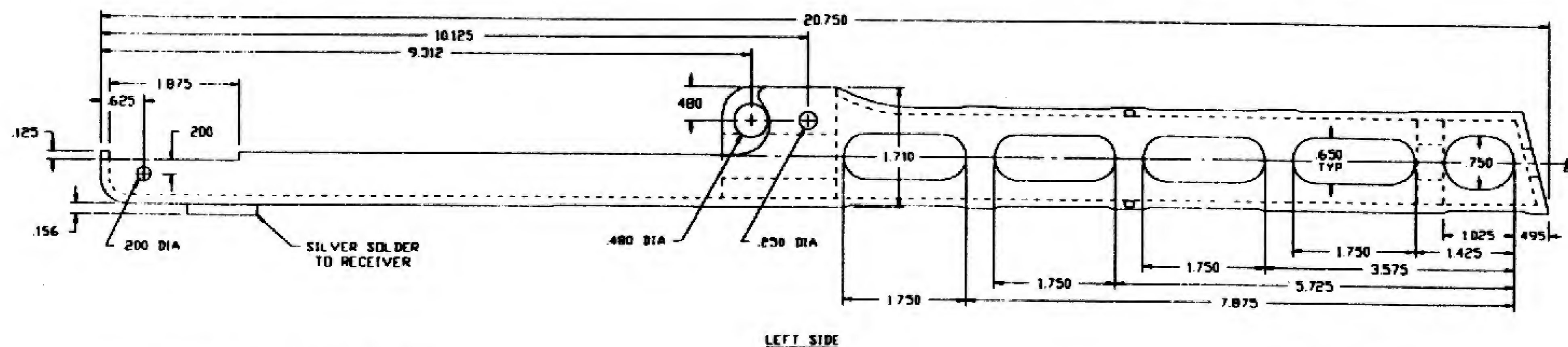
SECTION A-A



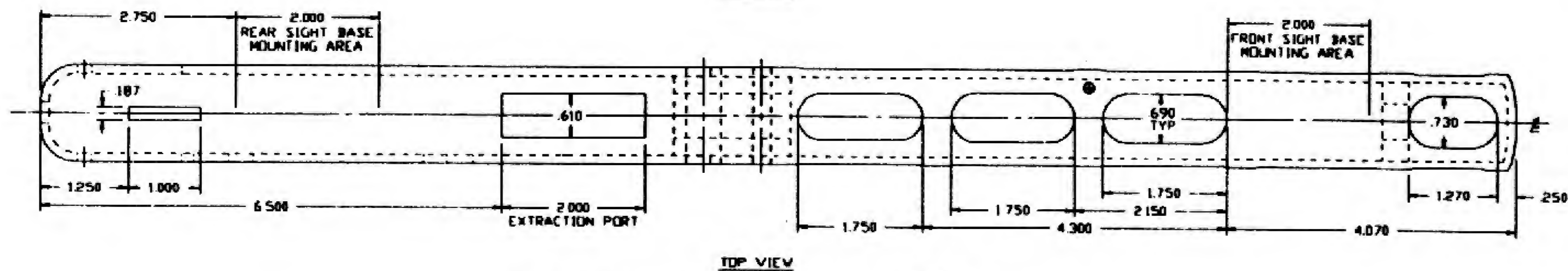
BOTTOM VIEW



SECTION B-B



LEFT SIDE



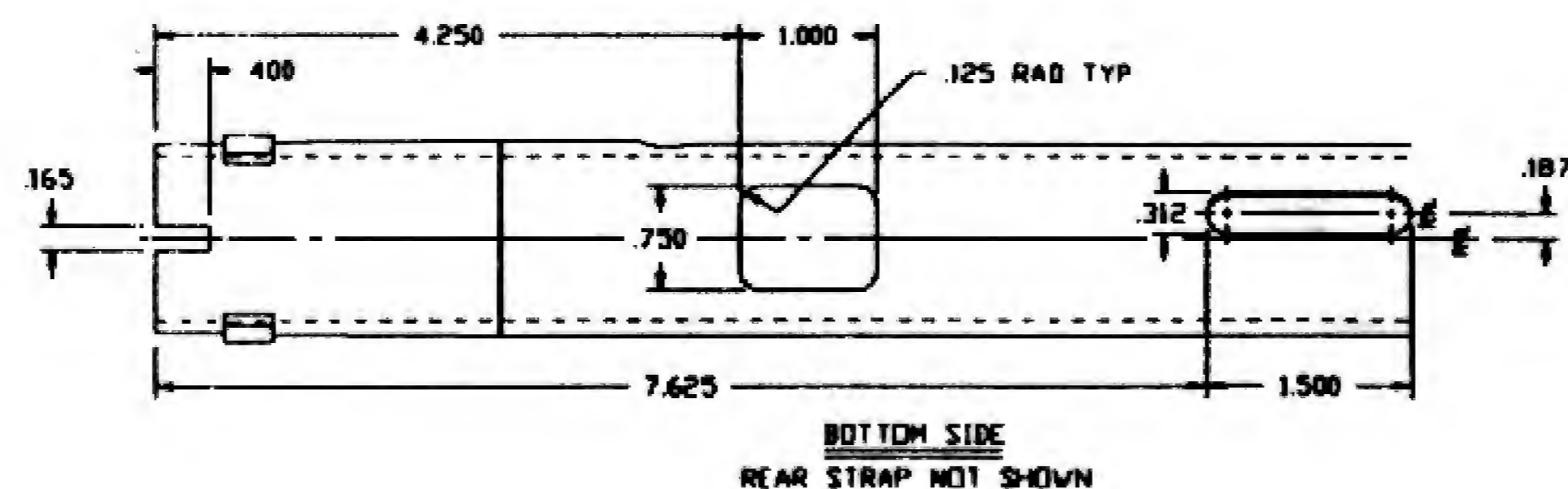
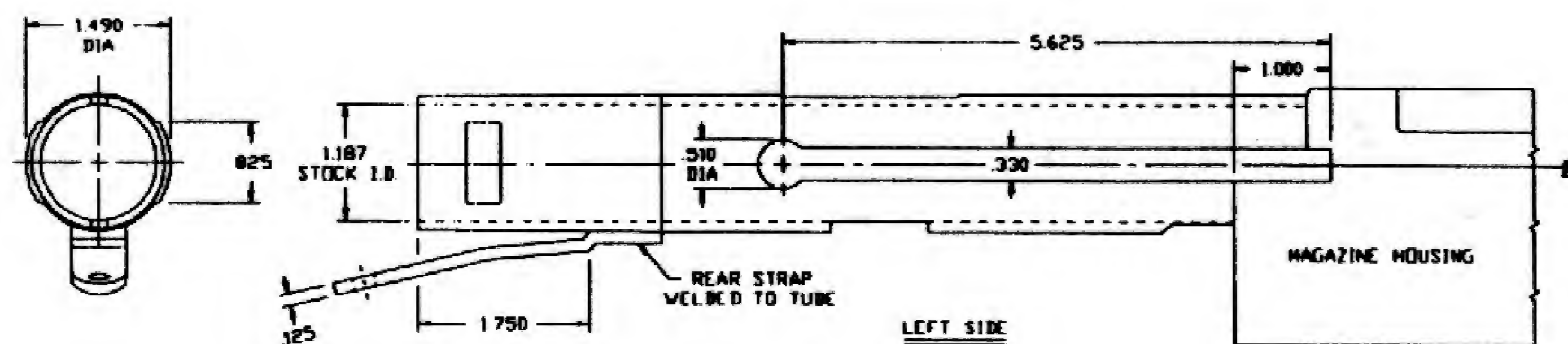
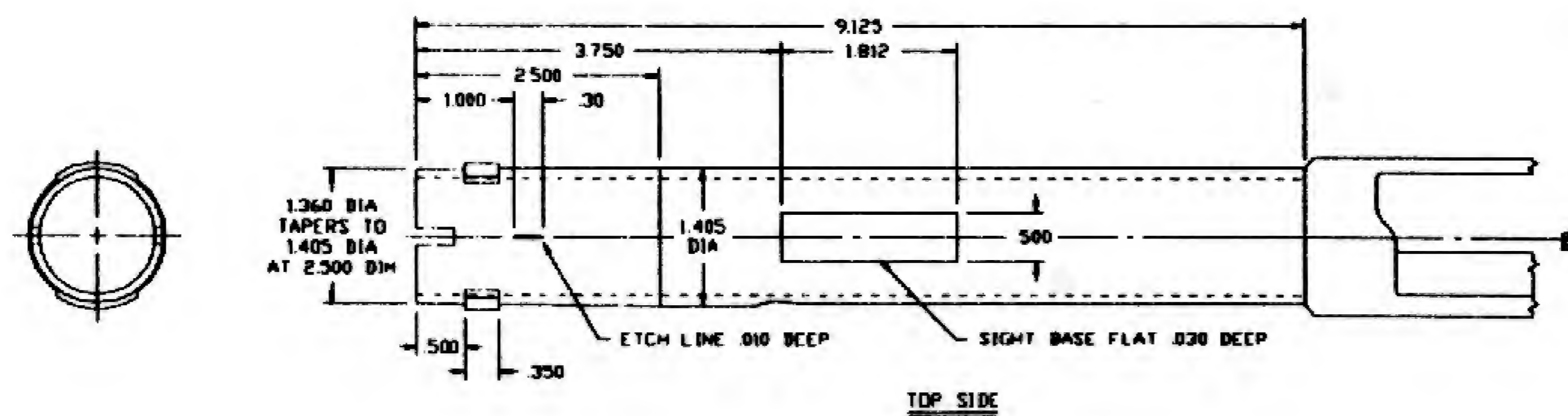
TOP VIEW

- NOTES:
1. MATERIAL - .125 MILD STEEL SHEET
 2. FINISH - BLUE
 3. CUTOUTS STAMPED THEN SHROUD AND BACK RADIUS FORMED

RESTRICTED
MATERIAL

CONFIDENTIAL

SCALE: FULL	MATERIAL: SEE NOTE 1	DATE:	TOLERANCES: HOLE ± .01 OTHER ± .02
DATE:	FINISH: SEE NOTE 2	DATE:	HOLE ± .01 OTHER ± .02
TITLE: RUSSIAN SUBMACHINE GUN PPSH-41	REV.	DATE:	ANGLE ± .5°



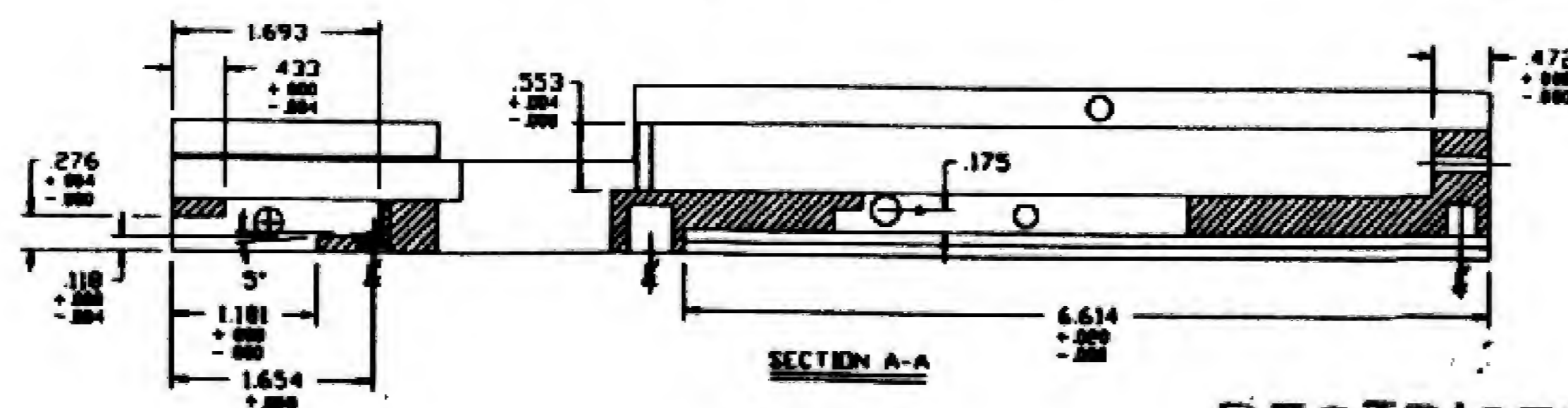
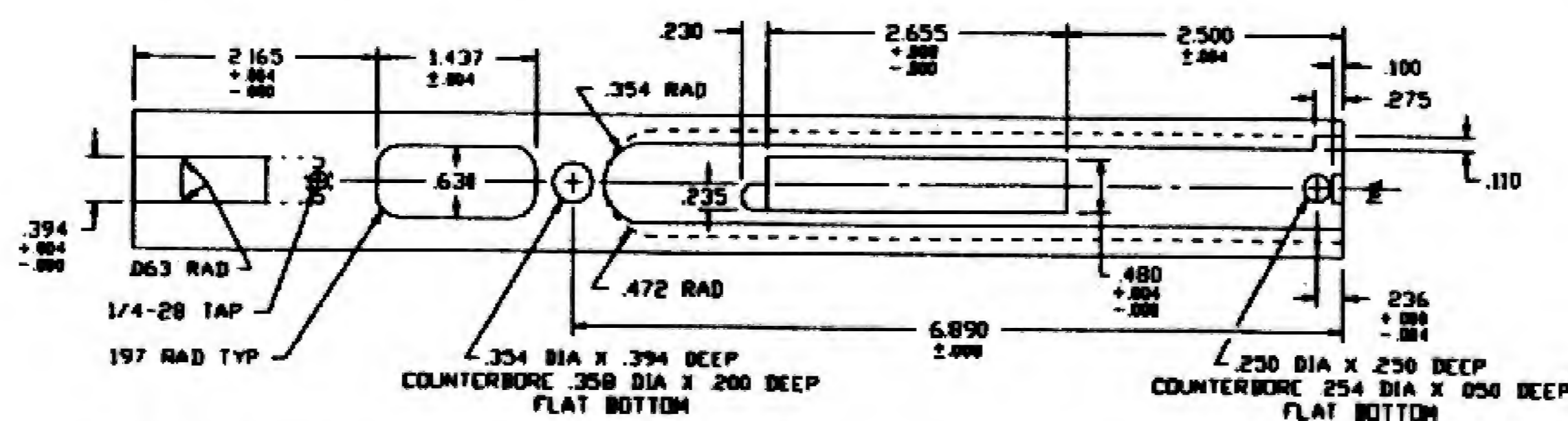
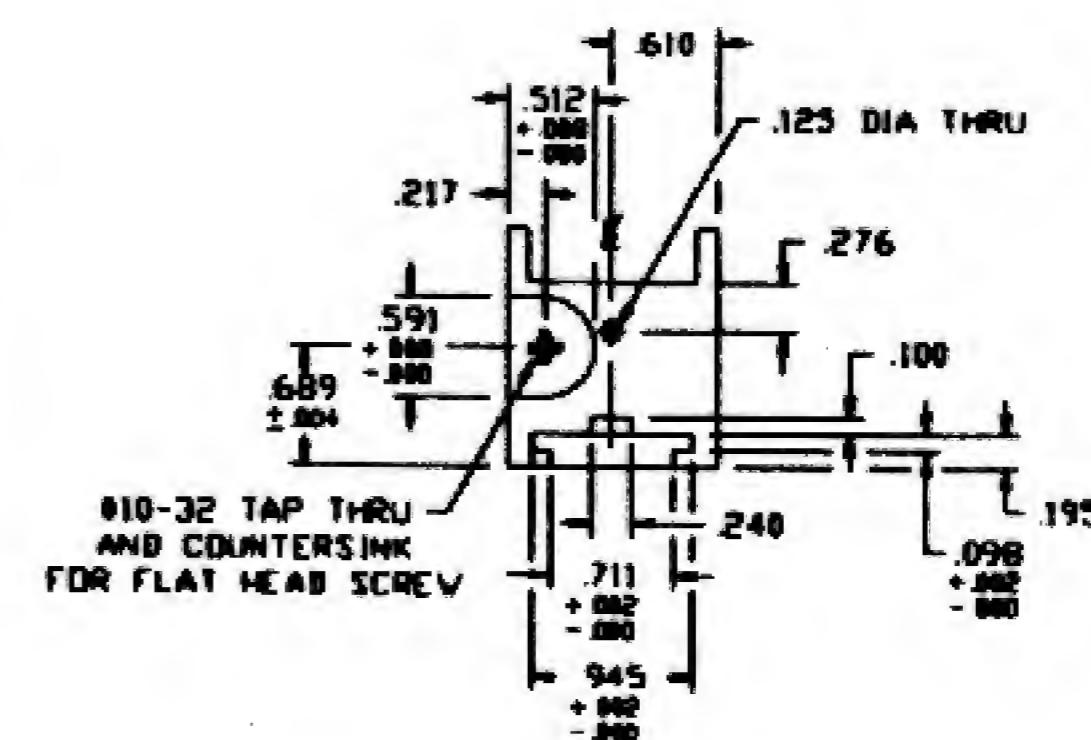
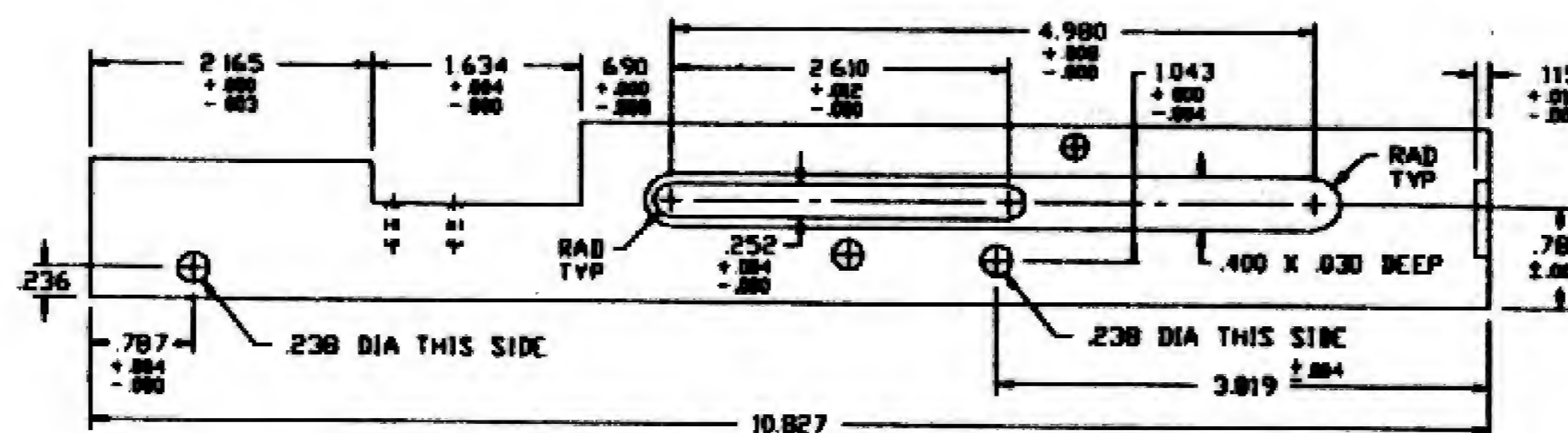
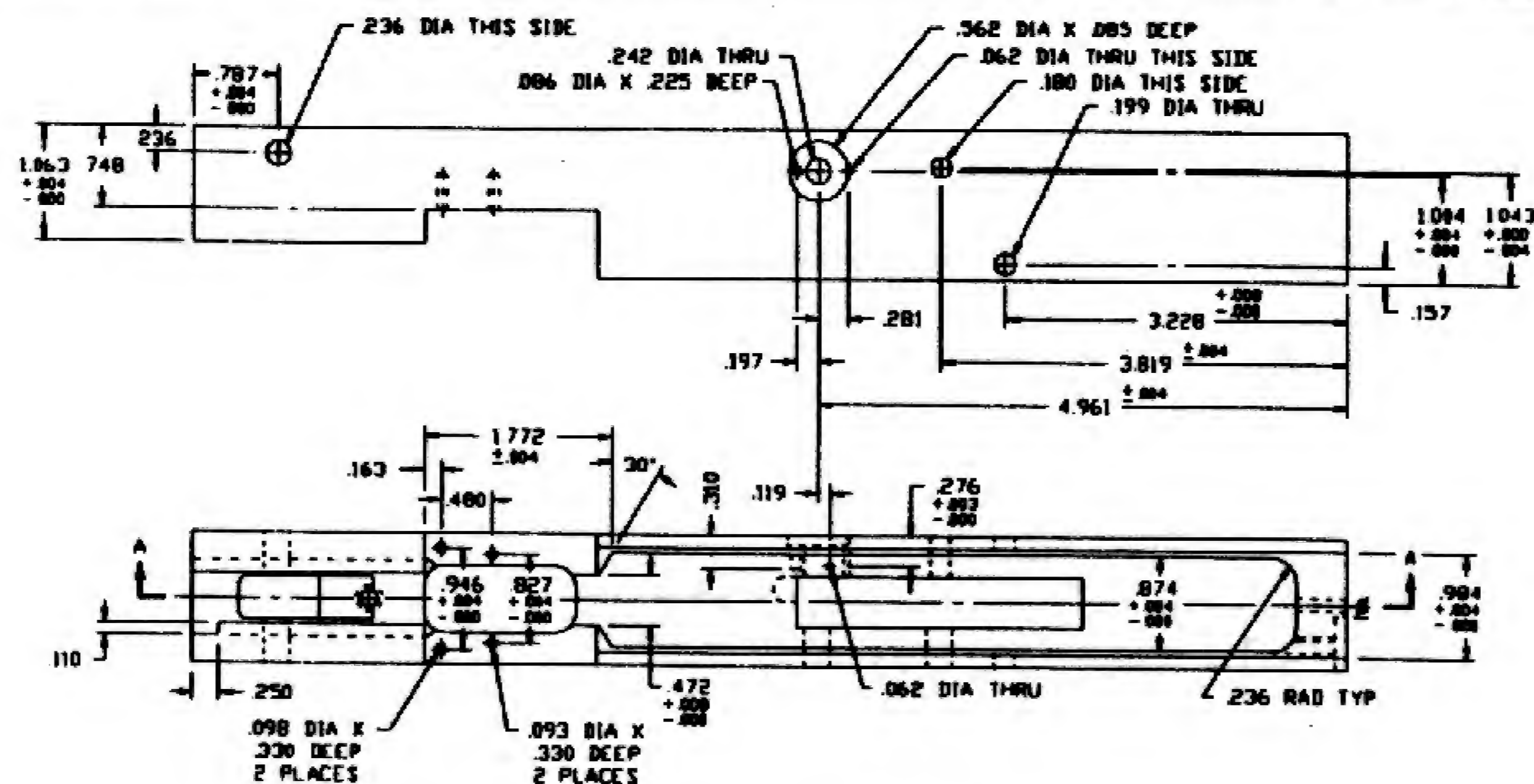
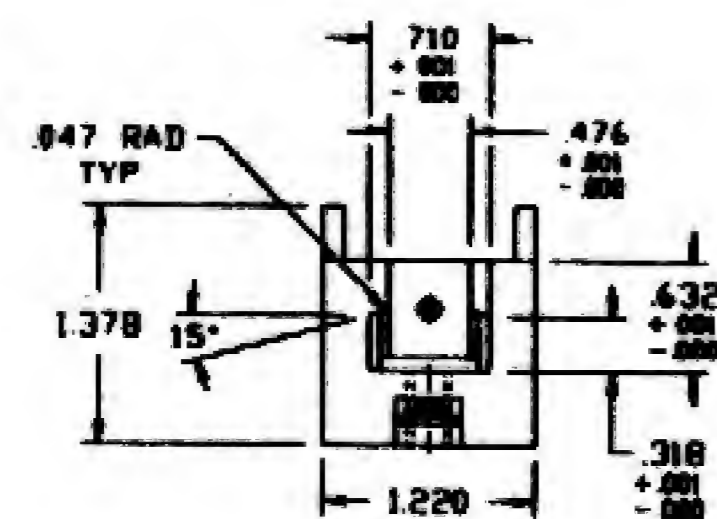
CONFIDENTIAL

NOTES

1. MATERIAL - 1.500 O.D. X 1.187 I.D. D.O.M. STEEL TUBE
2. FINISH - BLUE
3. CALIBER - 7.62 TOKAREV
4. THE ORIGINAL RECEIVER WAS THE FULL LENGTH OF GUN. IT WAS MADE FROM ROLLED STEEL AND WELDED FULL LENGTH. THE HOUSING WAS BRAZED IN PLACE AND ALL VOIDS WERE FILLED WITH BRASS.
5. THIS RECEIVER TUBE IS CUT TO A LENGTH AND BUTT WELDED TO EXISTING PORTION OF RECEIVER TUBE. FINAL OVERALL LENGTH TO BACK OF MAGAZINE HOUSING SHOULD BE 9.125.

**RESTRICTED
MATERIAL**

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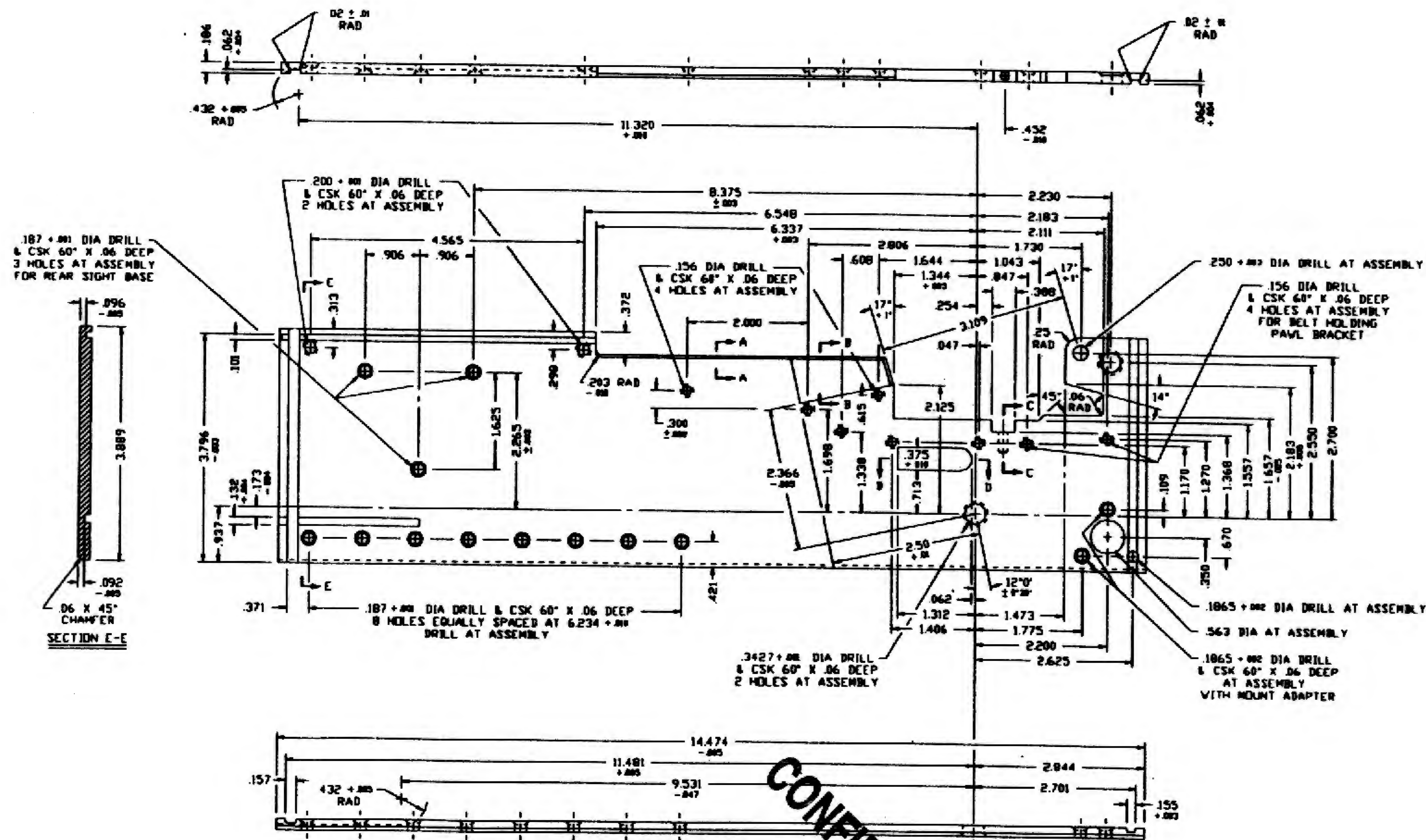


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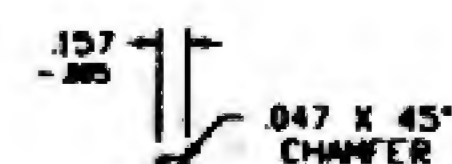
- NOTES:
 1. MATERIAL - ALUMINUM 6061-T6
 2. FINISH - ANODIZE, DYE BLACK

**RESTRICTED
MATERIAL**

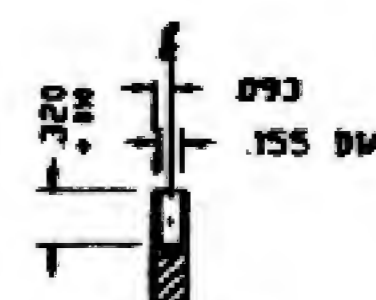
SCALE	FULL	MATERIAL	SEE NOTE 1	CRS	DATE	REVISIONS
DATE		FINISH	SEE NOTE 2	DATE		
FILE	AMERICAN 100 RECEIVER (FULL AUTO)				REV.	
						40



SECTION A-A



SECTION B-B



SECTION C-C



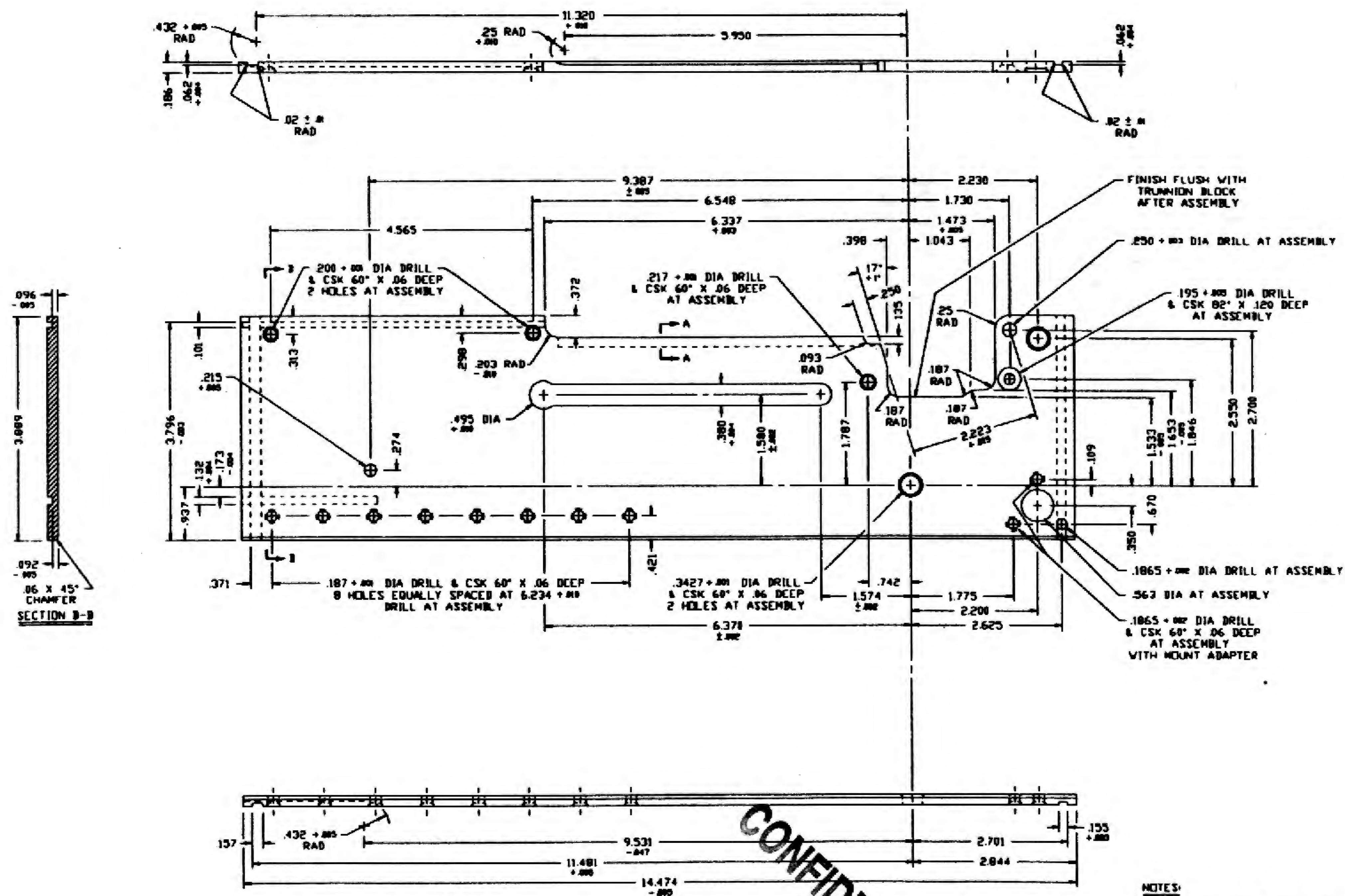
SECTION D-D

RESTRICTED
MATERIAL

NOTES:

1. MATERIAL- 4130 PLATE OR Q1. FLAT GROUND STOCK
2. FINISH- PARKERIZE
3. ORIGINAL MATERIAL STEEL FS4042, FS4047, FS4640 PER MIL SPEC 68-S-624
4. HEAT TREAT REAR END FOR ONE INCH ROCKWELL "C"43-49
ANNEAL AROUND TWO HOLES.

DATE	FULL	MATERIAL	SEE NOTE 1	CHK	REVISIONS
DATE		FORM	SEE NOTE 2	DATE	REV. 1
TITLE	BROWNING M919A4 AND A6 LEFT HAND SIDE PLATE				REV. 2
NO.					NO.



RESTRICTED
MATERIAL

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NOTES:

1. MATERIAL - 4130 PLATE OR OH. FLAT GROUND STOCK
2. FINISH - PARKERIZE
3. ORIGINAL MATERIAL STEEL FS4042, FS4047, FS4640 PER MIL SPEC 60-S-624
4. HEAT TREAT REAR END FOR ONE INCH ROCKWELL "C" 43-49
ANNEAL AROUND TWO HOLES.

SCALE: FULL	MATERIAL: SEE NOTE 1	CHK	TEL. PROJECT
DATE	FINISH: SEE NOTE 2	DATE	REV. 1
TITLE: BROWNING M919A4 AND A6 RIGHT HAND SIDE PLATE	REV.	NO.	REV. 2

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

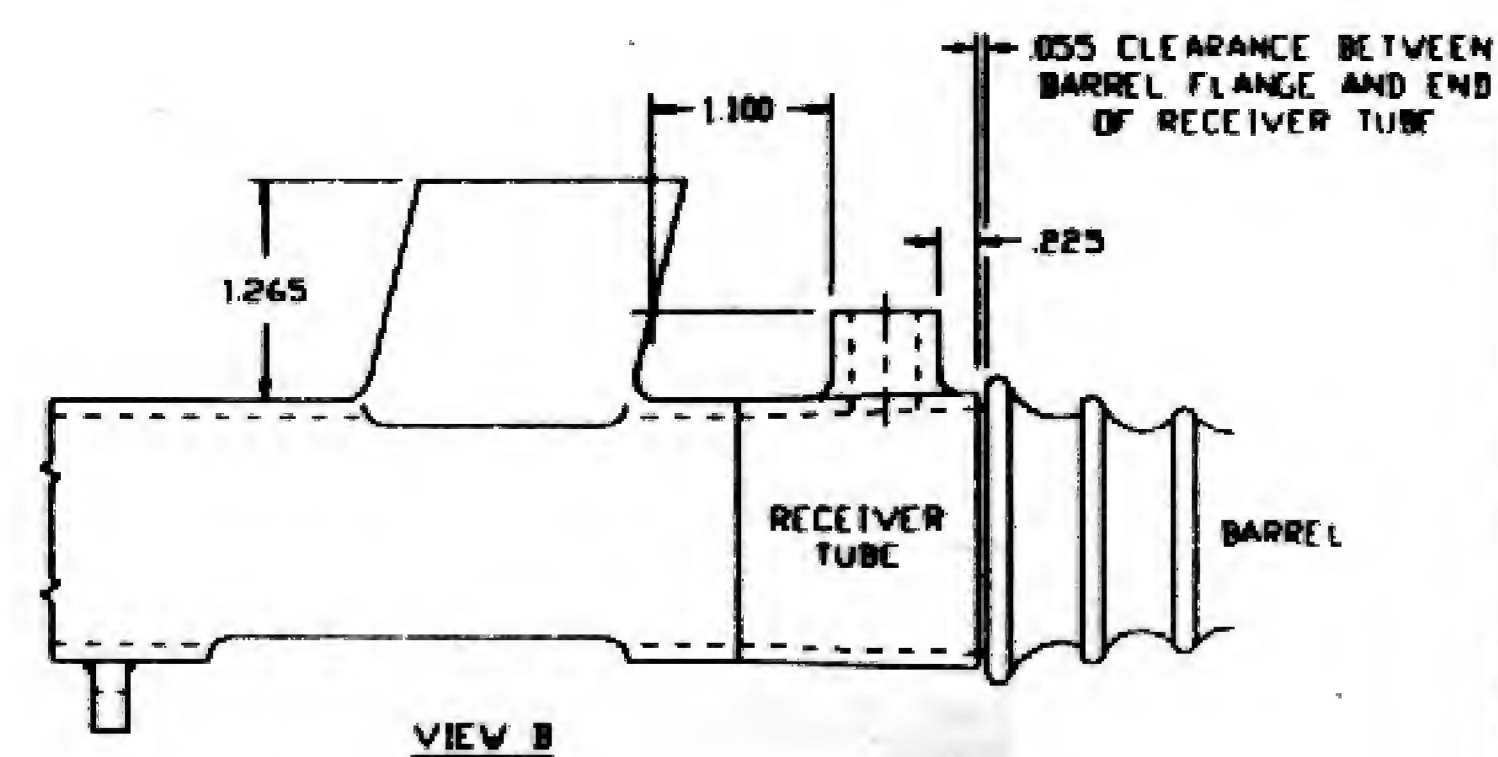
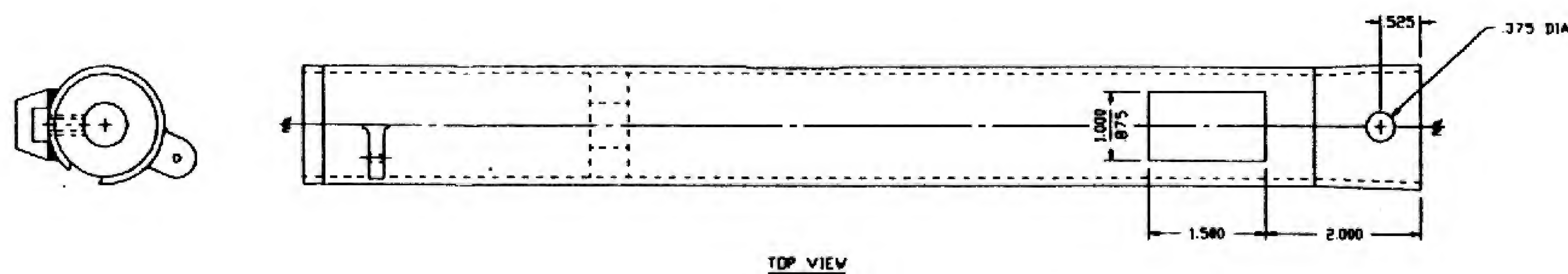
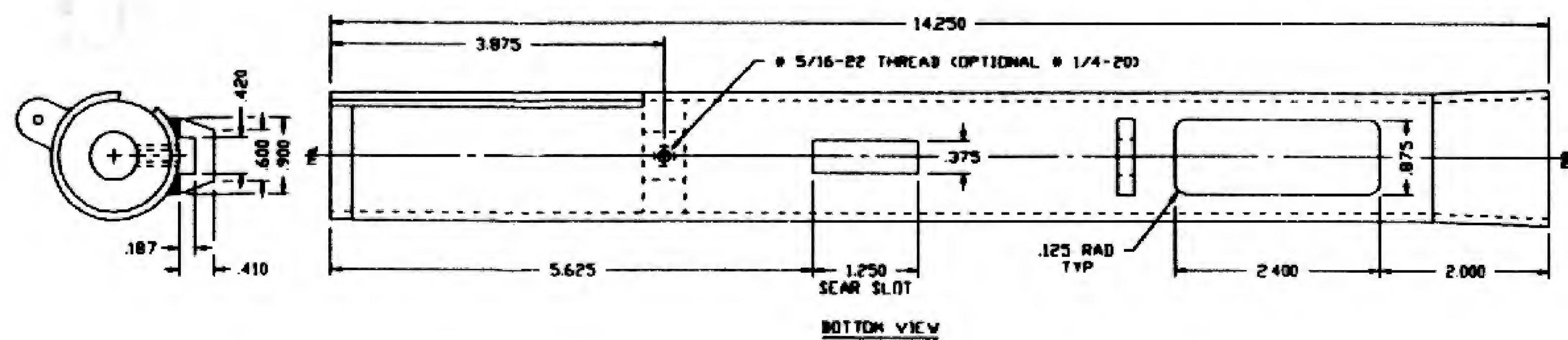
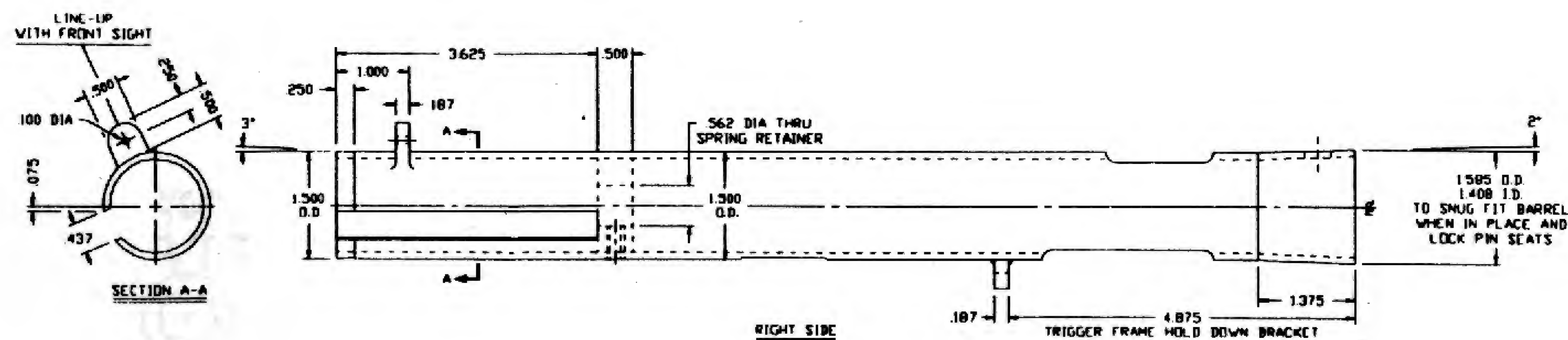
**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**



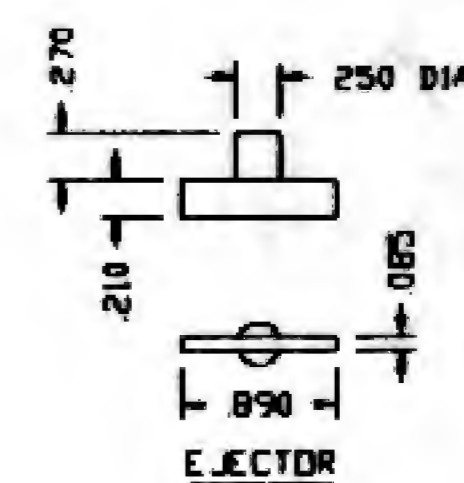
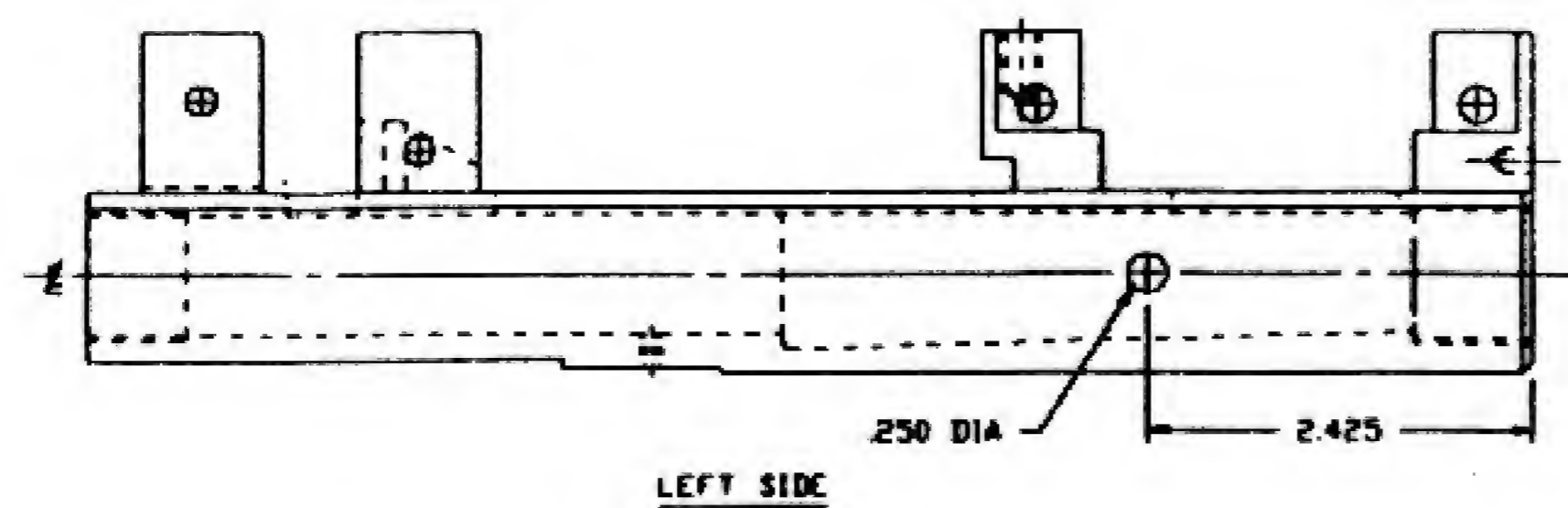
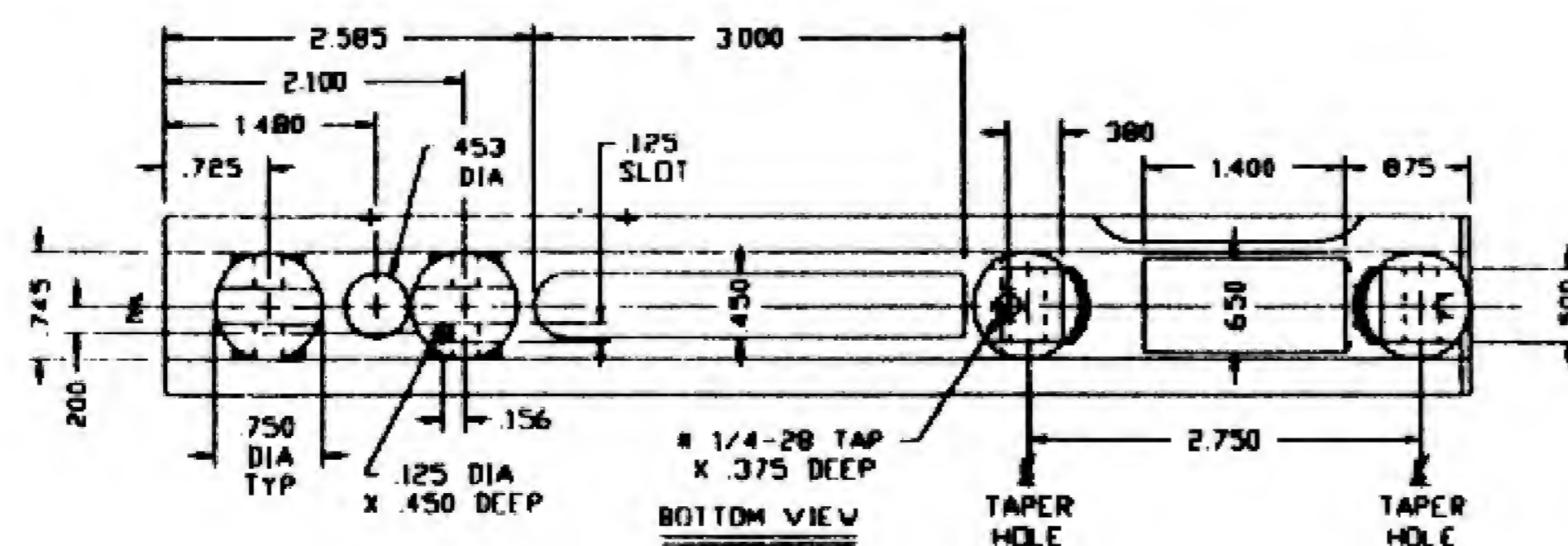
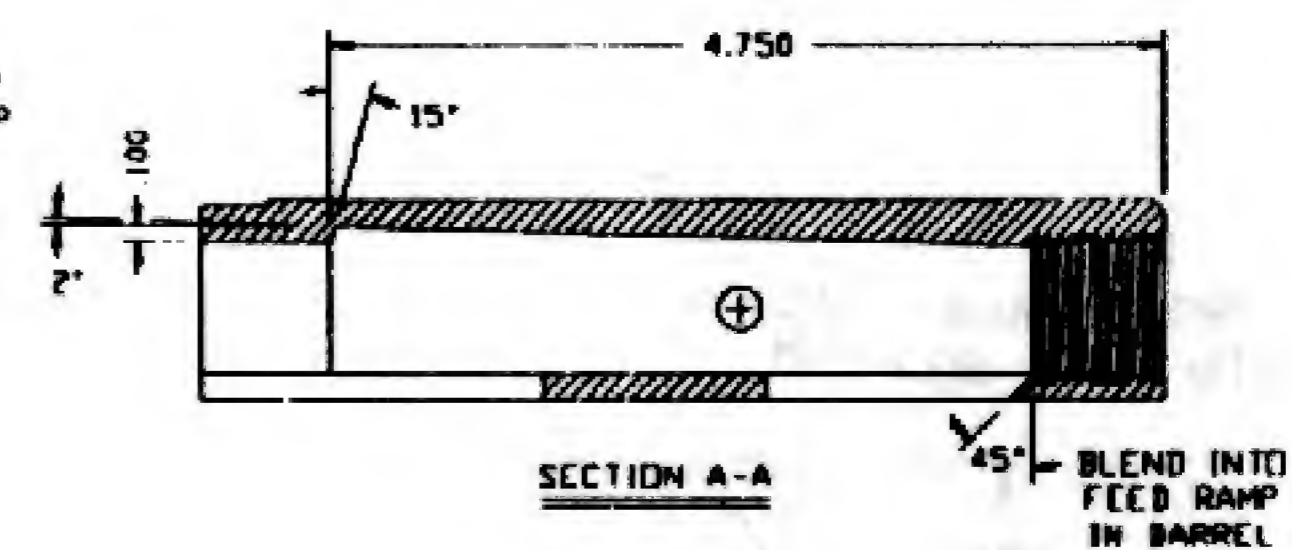
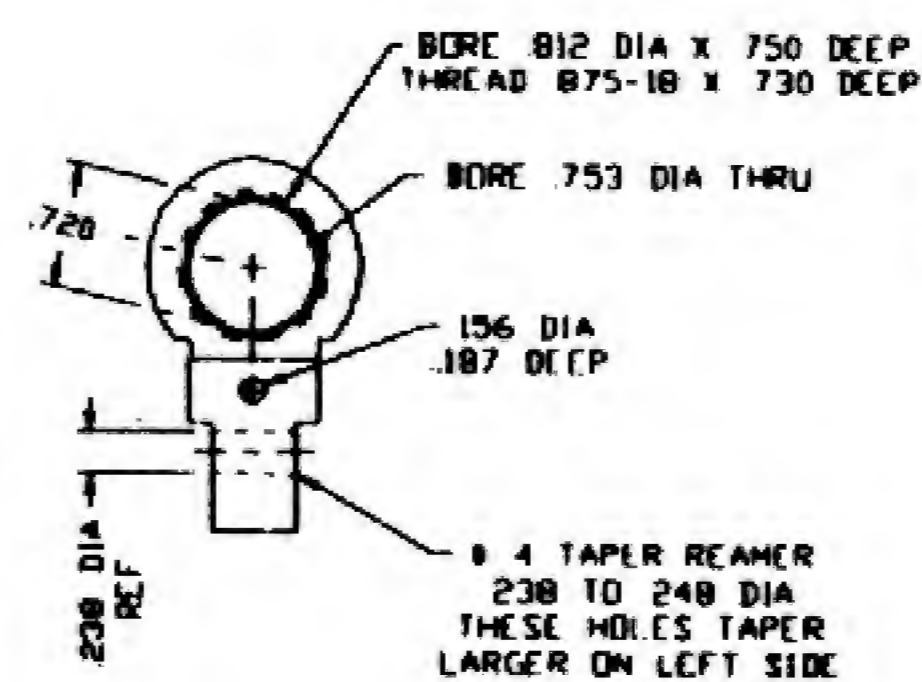
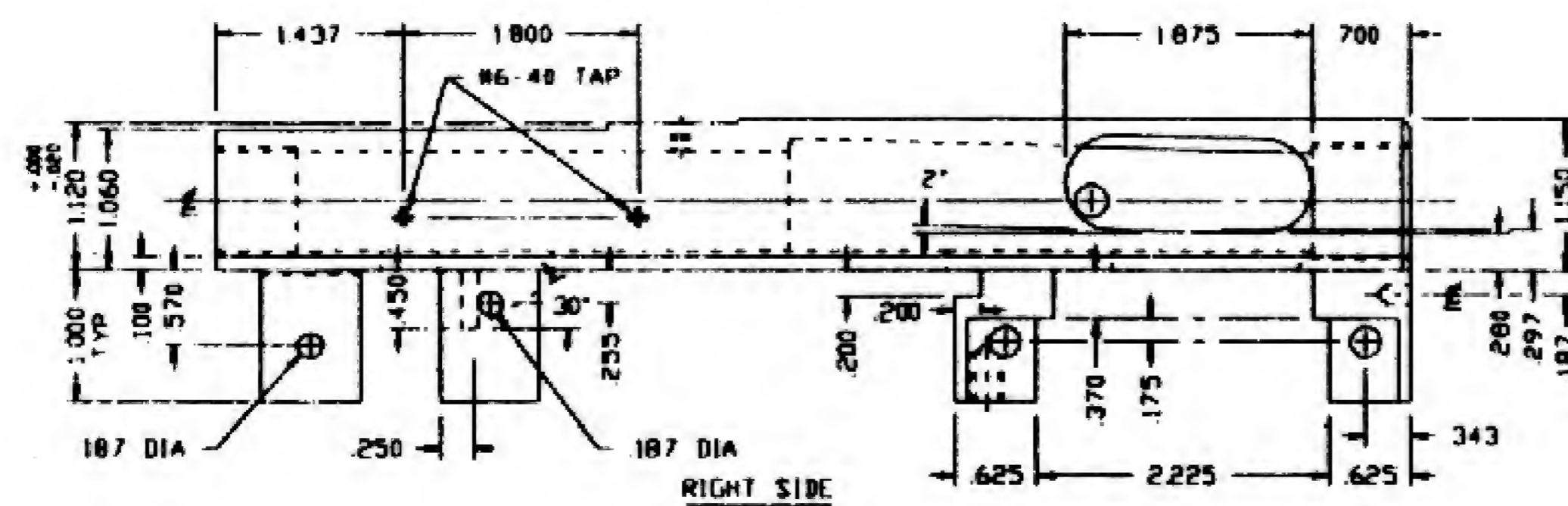
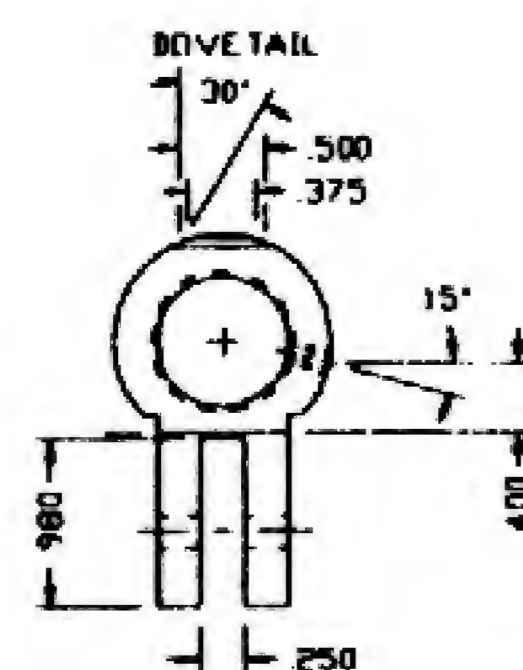
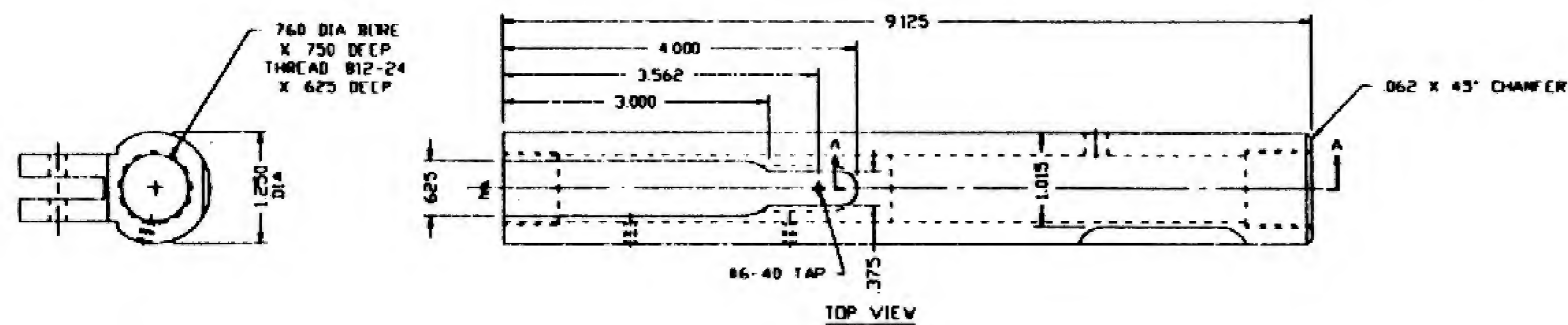
NOTES

1. MATERIAL- 1625 O.D. X 1.312 I.D. DDM STEEL TUBE
2. FINISH- PARKERIZE THEN PAINT BLACK OR CAMOFLAGE
3. SOME PART KITS COME WITH FRONT RECEIVER PARTS IN FACT. IF THIS IS YOUR CASE, THEN REAR PART OF RECEIVER TUBE CAN BE ALIGNED AND BUTT WELDED.
4. IF PARTS ARE LOOSE, REFER TO 'VIEW B' FOR THEIR LOCATION
5. 5/16-22 THREAD IS BRITISH AND CAN BE SUBSTITUTED WITH #7 DRILL (.201 DIA) AND TAP # 1/4-20 THREAD. REPLACE ORIGINAL 5/16 SCREW WITH # 1/4-20 ROUND HEAD SCREW
6. SPRING RETAINER IS 1.312 O.D. WITH .562 DIA HOLE IN CENTER AND .500 WIDE. WELD IN PLACE USING 3 OR 4 DRILLED HOLES EQUALLY SPACED IN RECEIVER TUBE AT 3.875 DIMENSION AFTER ARC WELDING SPRING RETAINER AND RECEIVER TUBE TOGETHER. DRILL AND TAP # 1/4-20 HOLE IN BOTTOM FOR TRIGGER FRAME HOLD DOWN SCREW.
7. WHEN 3" TAPER IS CUT ON REAR OF RECEIVER TUBE IT SHOULD MEASURE 1400 AT SMALL END. MUST COVER FITS IN PLACE OVER THIS TAPER.
8. EARLY MODEL BARRELS WERE FINISHED. LATE MODEL BARRELS WERE PLAIN.

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RESTRICTED MATERIAL

SCALE	FULL	MATERIAL	SEE NOTE 1	DATE	TEL. EXCHANGES REC. 2 P.M. - 5 P.M. JUL 2 P.M. - 5 P.M. AUG 2 P.M. - 5 P.M. SEPT 2 P.M. - 5 P.M.
FINISH		FINISH	SEE NOTE 2	DATE	
TITLE: OVEN MK II MODEL 1943 RECEIVER				REV.	
				NO.	



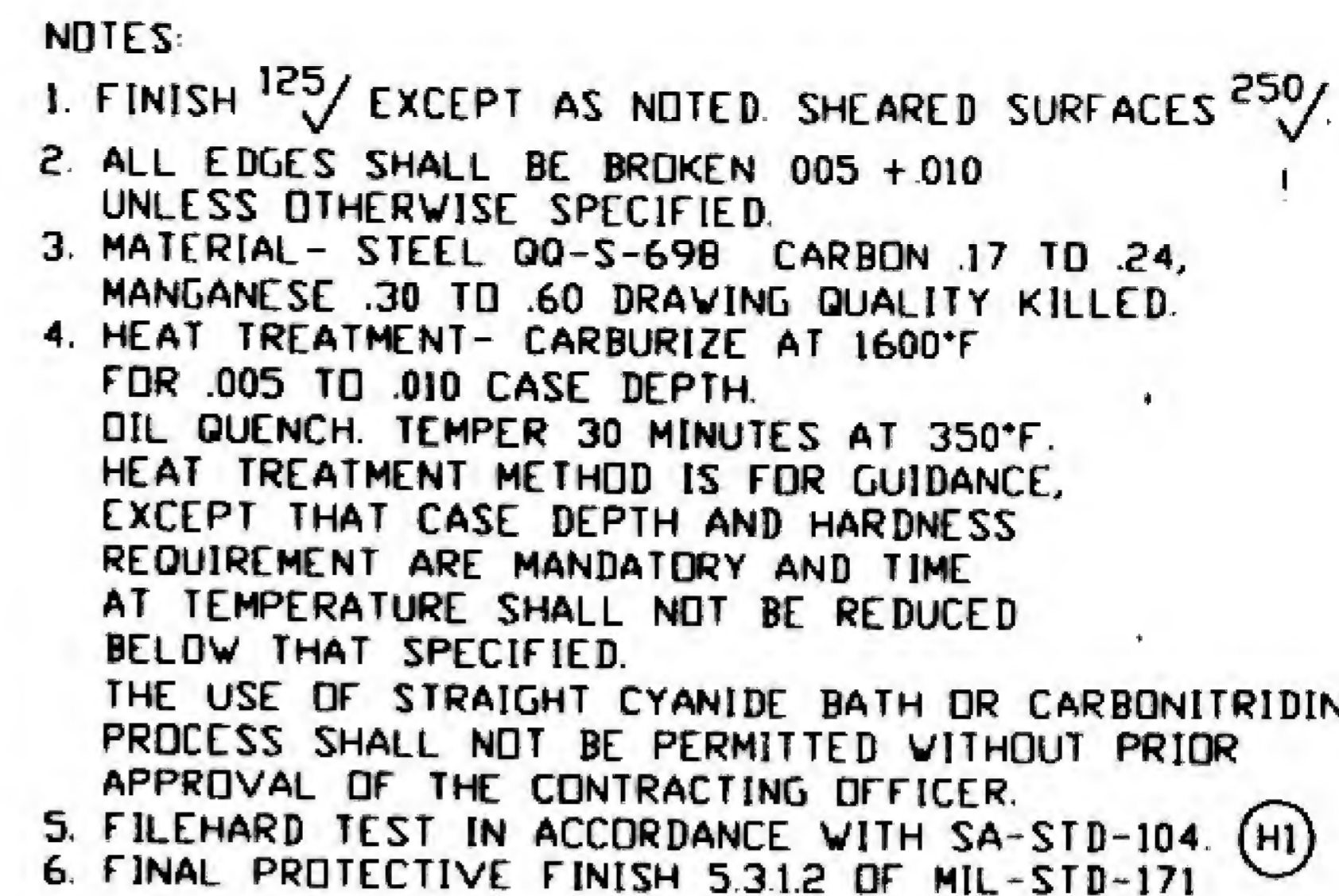
NOTES:

1. MATERIAL - 1020 STEEL DOM TUBING
2. FINISH - MILITARY 50 PARKERIZE, CIVILIAN 30 OR 60 BLUE
3. DARKENED AREAS AROUND 750 DIA POST REPRESENT ELECTRIC WELDS AFTER POSTS HAVE BEEN BRAZED OR SILVER BRAZED IN PLACE JUST LIKE ORIGINAL RECEIVER
4. 375 AREA OF SIGHT SLOT IS UNDERCUT WITH A 60° DOVETAIL CUTTER
5. EJECTION PORT IS ANGLED TO RESULT IN .280 DIMENSION IN FRONT AND 297 IN REAR
6. BORE OR REAM 753 DIA THRU HOLE BEFORE CUTTING OFF SET
7. SEMI AUTOMATIC RECEIVER CAN BE ACCOMPLISHED BY NOT CUTTING 125 SLOT WITH 30° RAMP AND .125 HOLE X .450 DEEP THIS WILL NOT ALLOW DISCONNECTOR TO BE ASSEMBLED

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**RESTRICTED
MATERIAL**

SCALE	FULL	MATERIAL	SEE NOTE 1	DES	TERMINES
DATE		FINISH	SEE NOTE 2	DATE	REC'D
TITLE	REISING RECEIVER			REV.	REC'D
				NO	REC'D



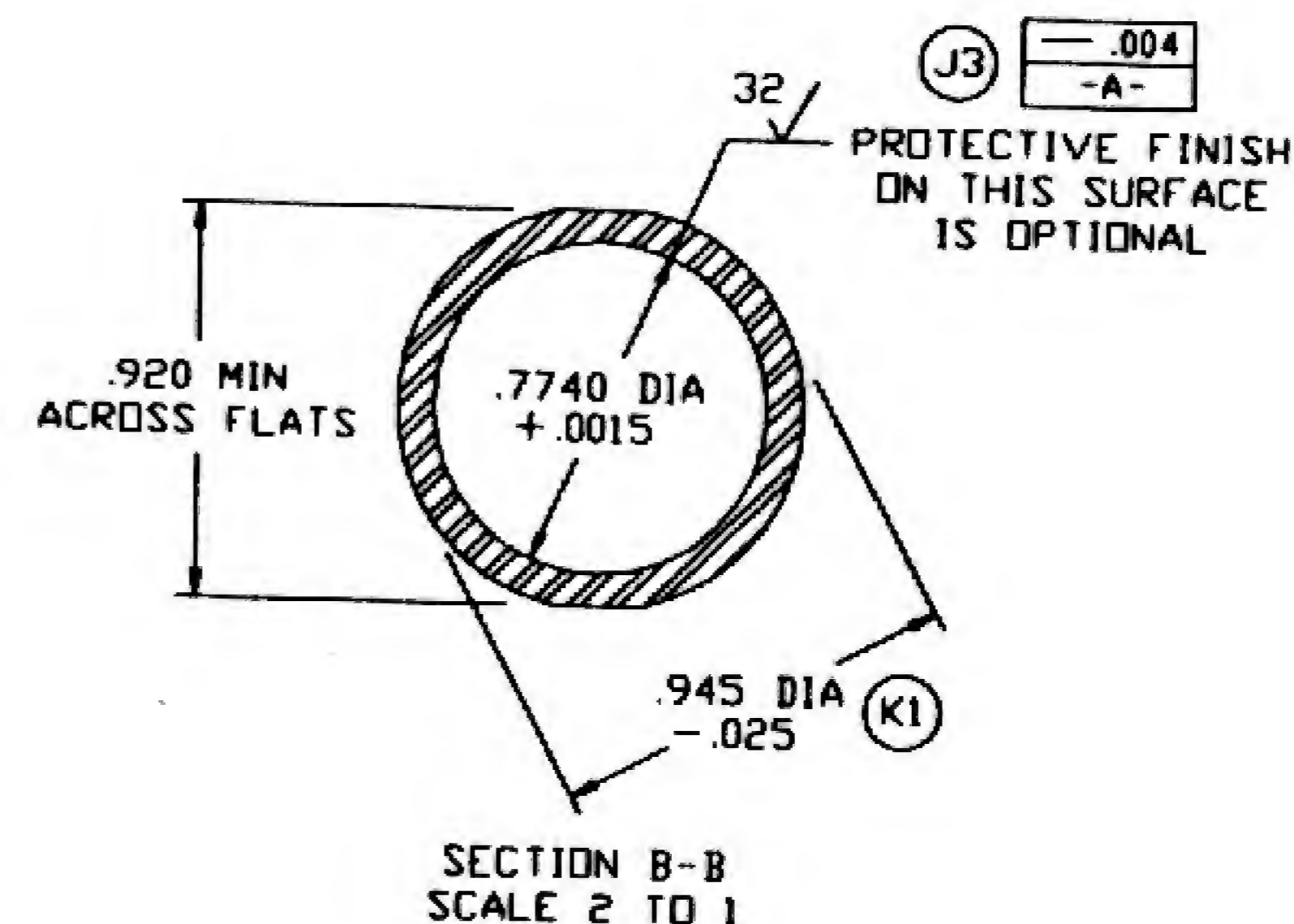
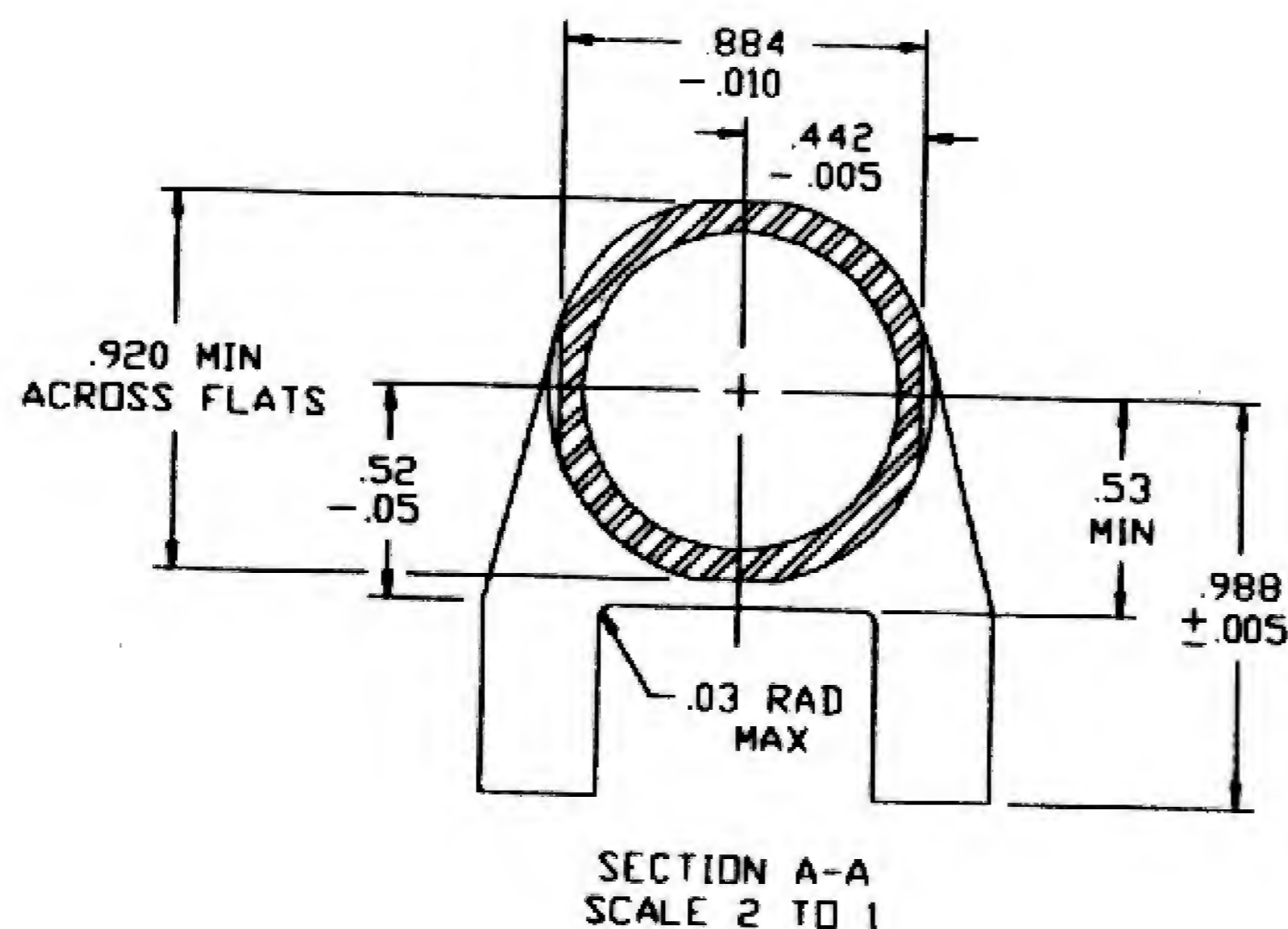
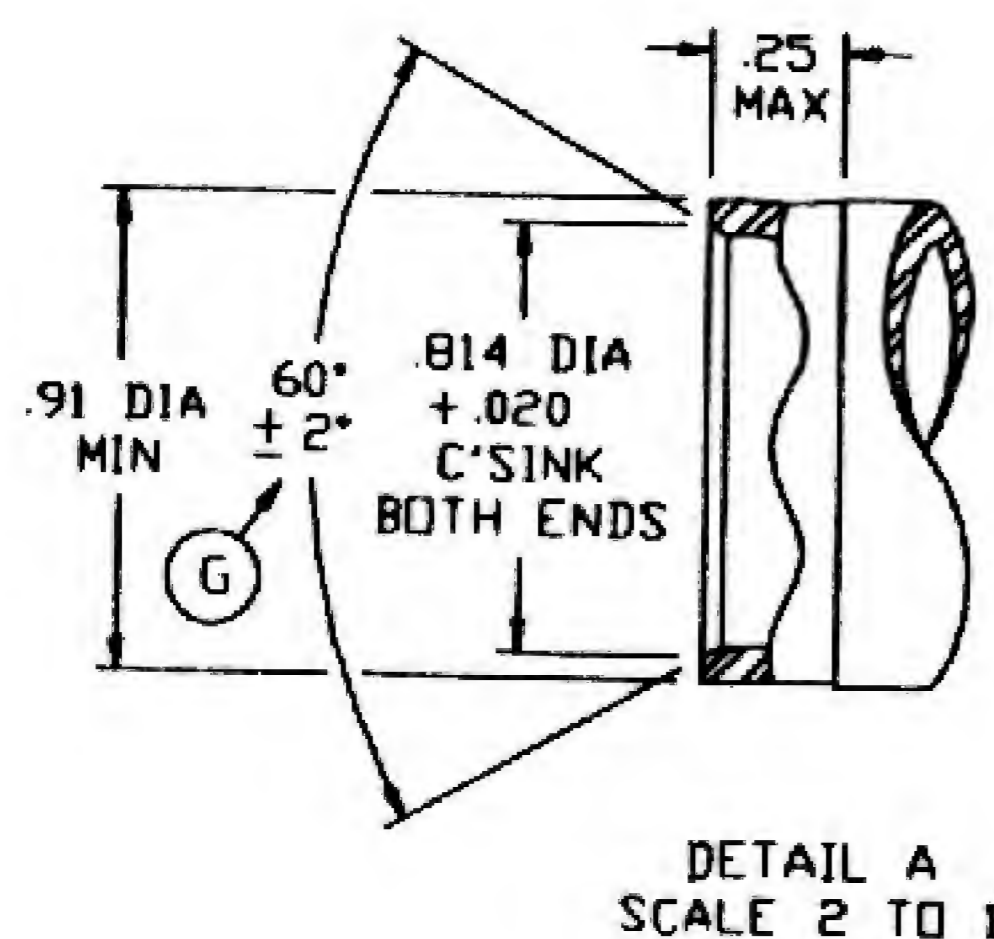
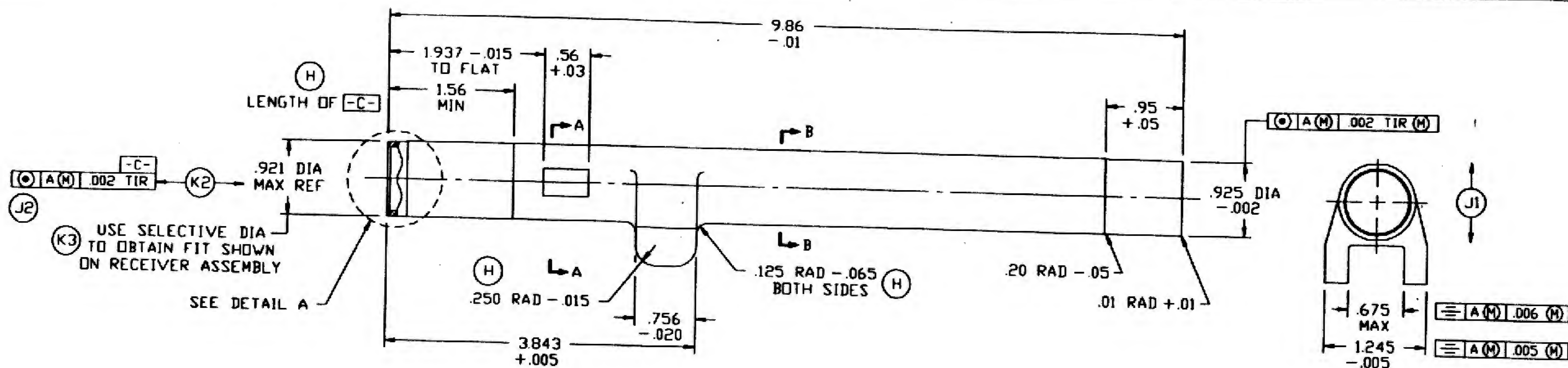
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NEXT ASSEMBLY	F11686308	MG , 7.62 MM - M60 , M60C
	F11699805	M60D

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269252
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SYM	DESCRIPTION
G	REDRAWN WITH CHANGE SEE EO NO. SA30116
H	(1) SEE EO HRD 82232

SCALE: 2 TO 1	MATERIAL: SEE NOTE 3	CKD.	TOLERANCES DEC ± .02 M M 2 PL ± .31 DEC ± .005 M M 3 PL ± .127 ANGLES ± .3°
DWN.	FINISH: SEE NOTE 1	DATE	
E TITLE: M60 BRIDGE, RECEIVER		REV.	NO



NOTES:

1. FINISH $125\sqrt{\text{EXCEPT AS NOTED. FORGED SURFACES } 250\sqrt{\text{J5}}$
2. MATERIAL - STEEL, COMP 4140, SPEC QQ-S-624 (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE COMPLIED WITH. (L1)
3. HEAT TREATMENT - HEAT AT 1525° TO 1575°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

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RESTRICTED MATERIAL

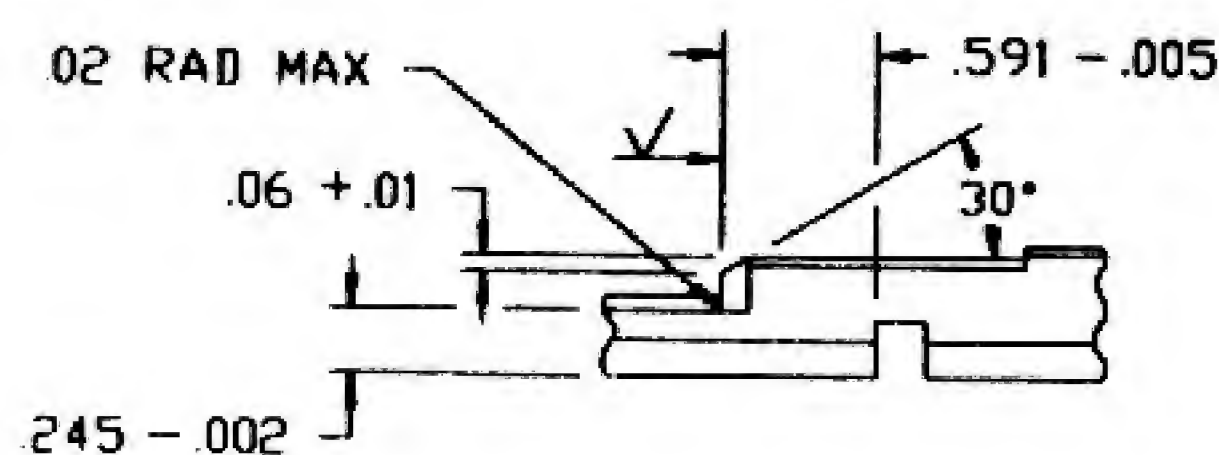
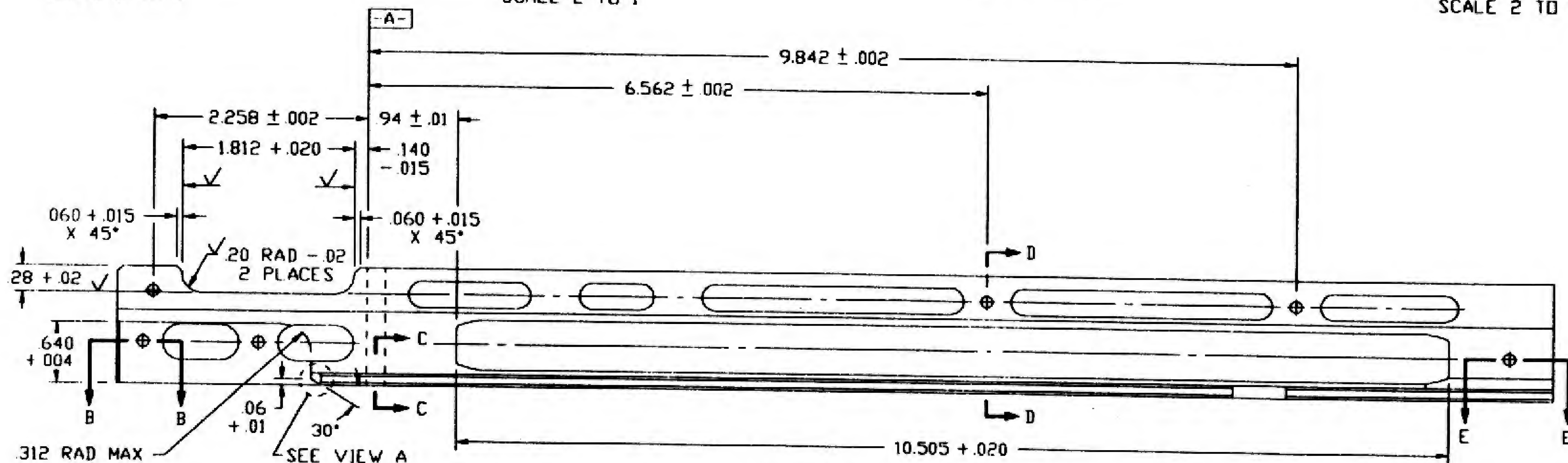
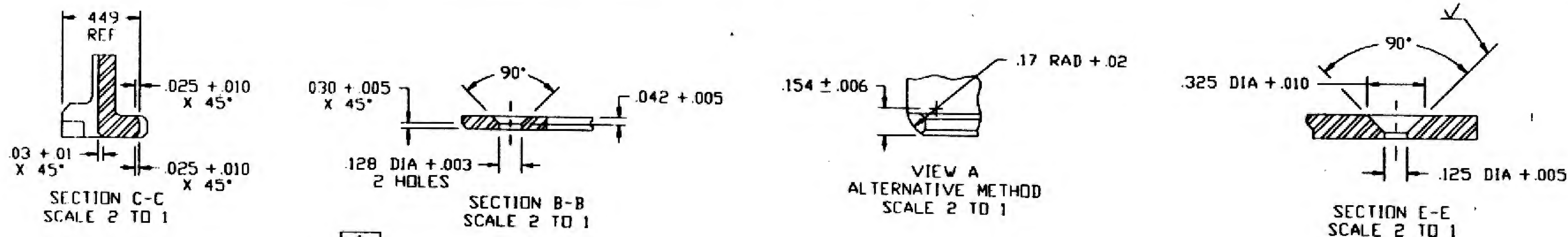
SYM	DESCRIPTION
E	
F	REDRAWN & REVISED SEE ED SA26085
G2	REF ED NO. SA27115
H5	REF ED NO. SA27297
J	(1-5) REF ED SA28042
K	(1-3) SEE ED SA29002
L	(1) SEE ED HRD 82370

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60C

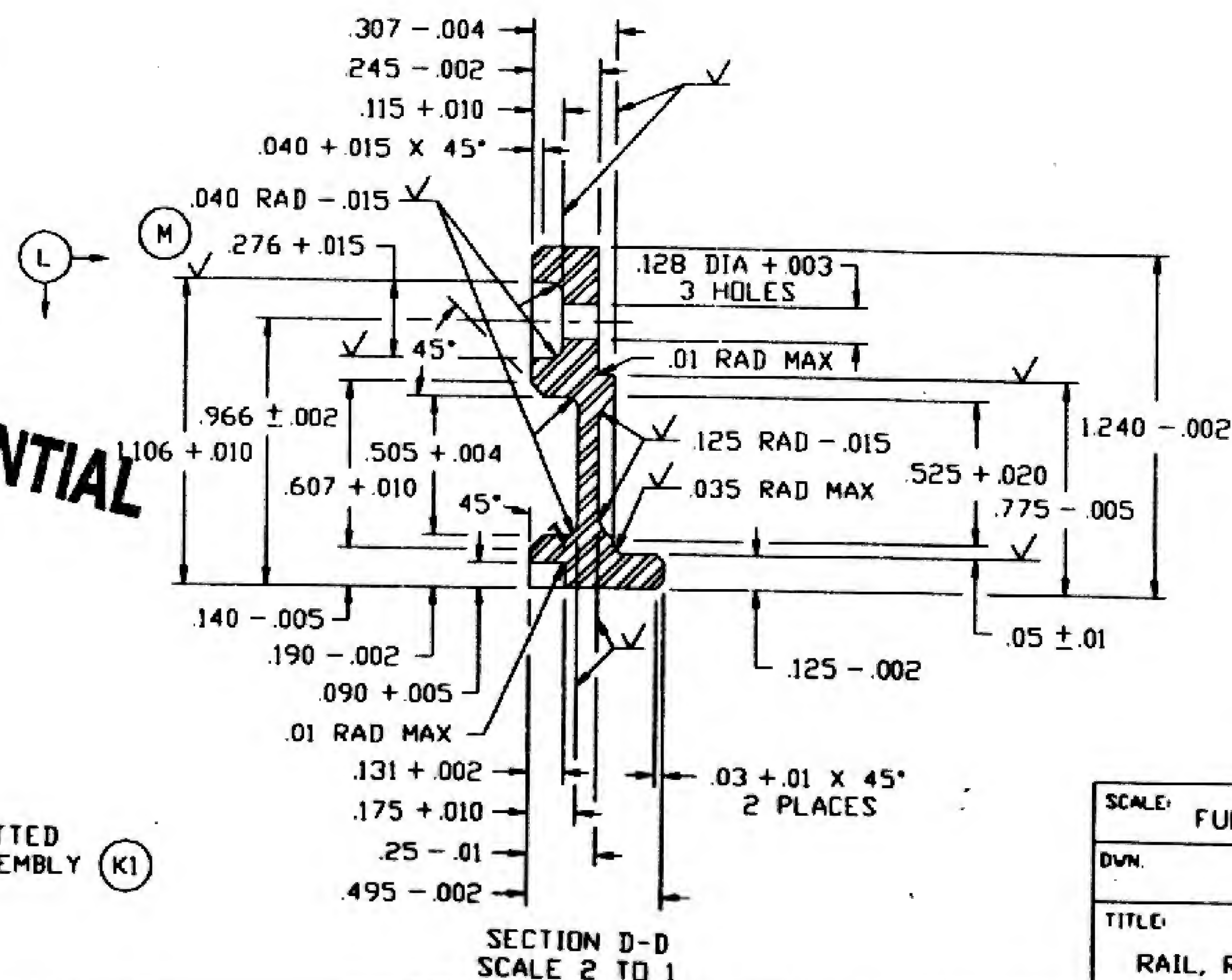
CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269256 (H)
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SCALE	MATERIAL	CKD.	TOLERANCES
FULL	SEE NOTE 2	DATE	DEC 2 PL ± .02
FIN.	FINISH SEE NOTE 1	REV.	DEC 3 PL ± .005
			DEC 3 PL ± .127
			ANGLES ± 5°
			NO.





VIEW F-F
(SEE SHEET 1)



**RESTRICTED
MATERIAL**

SYM	DESCRIPTION
J	REDRAWN WITH CHANGE SEE ED NO. 30122
K	(6) SEE ED HRD 82232
L	(1) SEE ERR HDR 10715
M	SEE ERR HDR 40604

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269258
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL

NOTE:
ALL RIVET HOLES AND THEIR COUNTERSINKS MAY BE OMITTED
OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY
TO THE DIMENSIONAL REQUIREMENTS APPLICABLE
AT THE COMPONENT LEVEL. (K1)

SCALE:	FULL	MATERIAL:	SEE SHEET 1	CKD.		TOLERANCES
DWN.		FINISH:	SEE SHEET 1	DATE		DEC 2 PL $\pm .02$ M H $\pm .31$
TITLE: M60 RAIL, RECEIVER, LEFT HAND				REV.		DEC 3 PL $\pm .005$ M H $\pm .127$ ANGLES $\pm 5^{\circ}$
						NO.

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**